MODEL G0706
12" PARALLELOGRAM JOINTER
OWNER'S MANUAL

FOR MODELS MANUFACTURED SINCE 11/09 #TR12332 PRINTED IN CHINA

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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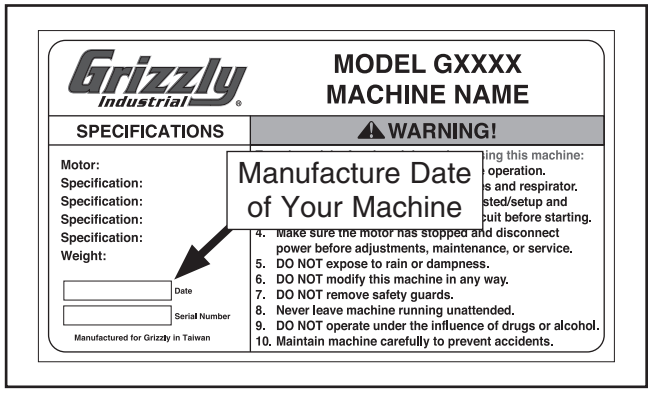
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes errors do happen and we apologize for them.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at **www.grizzly.com**. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

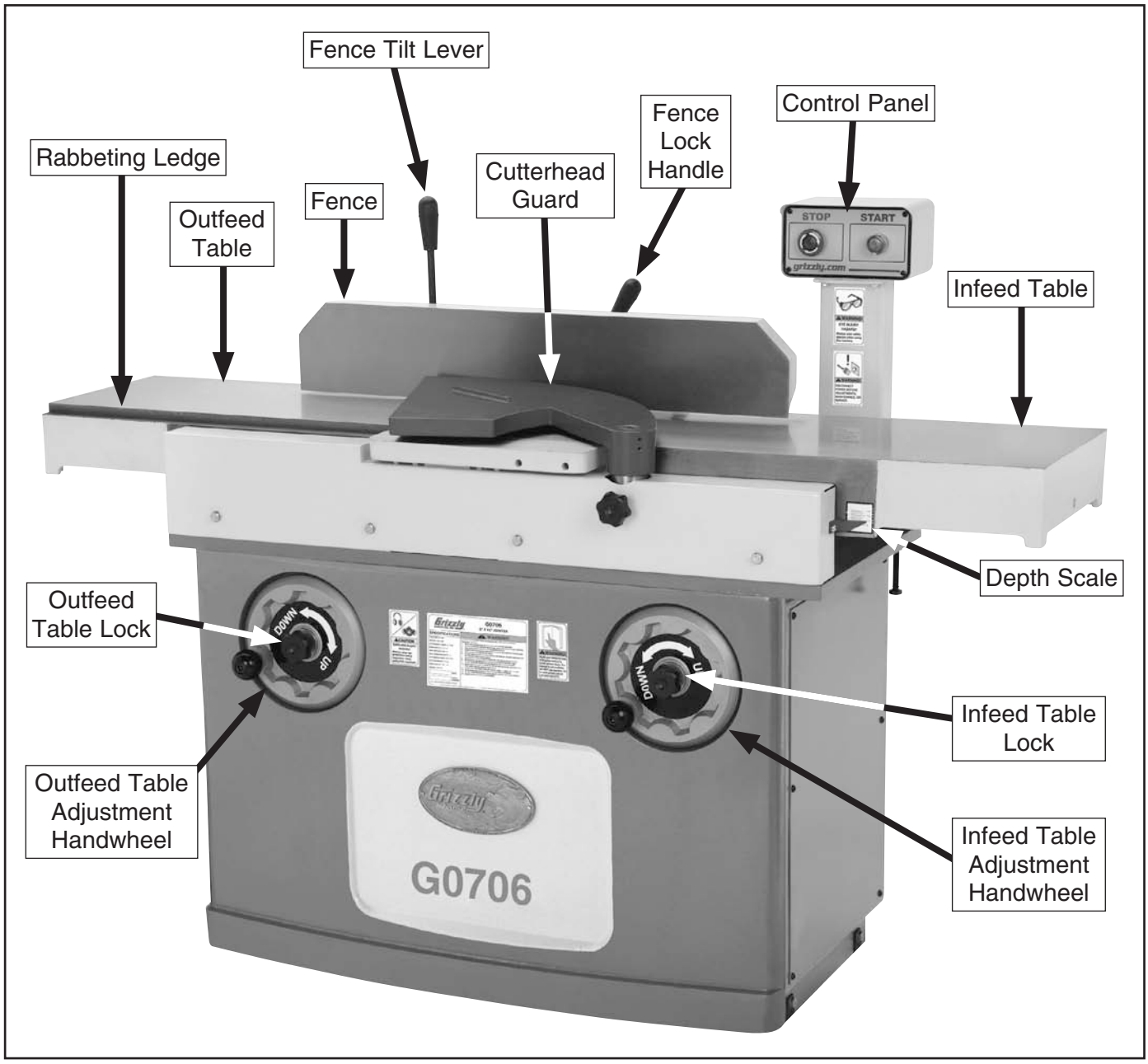
Machine Description

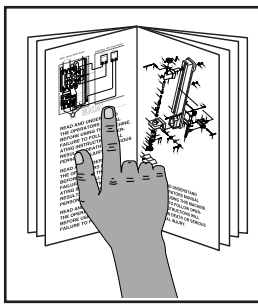
This jointer offers a 12" wide bed that is only 60" long. Since most other 12" jointers have beds that are typically over 80" long, this jointer can fit where others can't.

This jointer also features parallelogram tables that can be adjusted to a high degree of alignment with each other for extremely precise cutting results.

As with other jointers, the Model G0706 excels at face planing and edge jointing, which are two of the required steps for accurately squaring up wood stock, and are very helpful cuts when "cleaning" up the surface of a board. This jointer also has the capability to perform rabbet cuts up to 3/8" deep.

Identification





⚠WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0706
12" X 60" SHORT BED JOINTER W/ SPIRAL CUTTERHEAD

Product Dimensions:

Weight	695 lbs.
Length/Width/Height	60" x 30¾" x 43¼"
Foot Print (Length/Width)	39⅜" x 22⅜"

Shipping Dimensions:

Type	Wood
Content	Machine
Weight	834 lbs.
Length/Width/Height	63" x 34" x 39"

Electrical:

Power Requirement	220V, Single-Phase, 60 Hz
Switch	Magnetic with Thermal Overload Protection
Switch Voltage	220V
Cord Length	13 feet
Cord Gauge	12 gauge
Minimum Circuit SIze	20A
Plug Included	No
Recommended Plug Type	NEMA 6-20

Motors:

Main

Type	TEFC Capacitor Start Induction
Horsepower	3 HP
Voltage	220V
Phase	Single
Amps	15A
Speed	3450 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	Serpentine Belt Drive
Bearings	Shielded and Permanently Sealed

Main Specifications:

Cutting Capacities

Bevel Jointing	45°, 90°, 135°
Maximum Width of Cut	12"
Maximum Depth of Cut For a Single Pass	⅛"
Maximum Rabbeting Depth	⅜"
Number of Cuts Per Minute	19,800

Fence Information

Fence Length	31¼"
Fence Width	1⁹⁄₁₆"
Fence Height	5⅜"
Fence Stops	45º, 90º, 135º

Cutterhead Information

Cutterhead Type	Spiral
Cutterhead Diameter	3¾"
Number of Cutter Spirals	4
Number of Indexable Cutters	60
Cutter Insert Type	Carbide
Cutter Insert Length	14mm
Cutter Insert Width	14mm
Cutter Insert Thickness	2mm
Cutterhead Speed	4950 RPM

Table Information

Table Length	60"
Table Width	13"
Table Thickness	4⅛"
Floor to Table Height	31½"

Construction

Body Assembly Construction	Cast Iron
Cabinet Assembly Construction	Steel
Fence Assembly Construction	Cast Iron
Guard Construction	Aluminum
Table Construction	Cast Iron
Parallelogram	Yes
Paint.	Powder Coated

Table Information

Table Adjustment Type	Handwheel
Table Movement Type	Parallelogram

Other Information

Number of Dust Ports	1
Dust Port Size	5"

Other Specifications:

Customer Setup and Cleaning Time	30 Minutes
Warranty	1 Year
ISO Factory	ISO 9001
Country of Origin	China
Serial Number Location	ID Label on Center of the Stand

Features:

Parallelogram Table Adjustment
Fence is Center Mounted with Positive Stops at 45º, 90º, and 135º
Heavy-Duty Steel Cabinet
Independently Adjustable, Handwheel Precision Table Movement
Serpentine Drive Belt
Stress Relieved Infeed and Outfeed Tables
Pedestal Mounted ON/OFF Switch
Cast Aluminum Guard
5" Dust Port

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

⚠WARNING

Safety Instructions for Machinery

1. **READ ENTIRE MANUAL BEFORE STARTING.** Operating machine before reading the manual greatly increases the risk of injury.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

⚠WARNING
Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.

8. **KEEP CHILDREN/VISITORS AWAY.** Keep all children and visitors away from machinery. When machine is not in use, disconnect it from power, lock it out, or disable the switch to make it difficult for unauthorized people to start the machine.

9. **UNATTENDED OPERATION.** Leaving machine unattended while its running greatly increases the risk of an accident or property damage. Turn machine ***OFF*** and allow all moving parts to come to a complete stop before walking away.

10. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

11. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.

12. **USE A GROUNDED POWER SUPPLY RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Operating machine on an incorrect size of circuit increases risk of fire.

13. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY**. Make sure switch is in OFF position before reconnecting.

14. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**

16. **REMOVE CHUCK KEYS OR ADJUSTING TOOLS.** Make a habit of never leaving chuck keys or other adjustment tools in/on the machine—especially near spindles!

17. **DAMAGED MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, other conditions that may impair machine operation. Always repair or replace damaged parts before operation.

18. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.

19. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

20. **DO NOT OVERREACH.** Maintain stability and balance at all times when operating machine.

21. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

22. **STABLE MACHINE.** Machines that move during operations greatly increase the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

23. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.

24. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.

⚠WARNING
Additional Safety for Jointers

1. **JOINTER KICKBACK.** "Kickback" is when the workpiece is thrown off the jointer table by the force of the cutterhead. Always use push blocks and safety glasses to reduce the likelihood of injury from “kickback.” If you do not understand what kickback is, or how it occurs, **DO NOT** operate this machine.

2. **CUTTERHEAD ALIGNMENT.** Keep the top edge of the outfeed table aligned with the edge of the cutterhead at top dead center (TDC) to avoid kickback and personal injuries.

3. **PUSH BLOCKS.** Always use push blocks whenever surface planing. Never pass your hands directly over the cutterhead without a push block.

4. **WORKPIECE SUPPORT.** Supporting the workpiece adequately at all times while cutting is crucial for making safe cuts and avoiding injury. Never attempt to make a cut with an unstable workpiece.

5. **KICKBACK ZONE.** The "kickback zone" is the path directly through the end of the infeed table. Never stand or allow others to stand in this area during operation.

6. **MAXIMUM CUTTING DEPTH.** The maximum cutting depth for one pass is ⅛". Never attempt any single cut deeper than this!

7. **JOINTING WITH THE GRAIN**. Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip out. Always joint with the grain.

8. **KEEPING GUARDS IN PLACE.** With the exception of rabbeting, all operations must be performed with the cutterhead guard in place. After rabbeting, be sure to replace the guard.

9. **PROPER CUTTING.** When cutting, always keep the workpiece moving toward the outfeed table until the workpiece has passed completely over the cutterhead. Never back the work toward the infeed table.

10. **USING GOOD STOCK.** Jointing safety begins with your lumber. Inspect your stock carefully before you feed it over the cutterhead. Never joint a board that has loose knots, nails, or staples. If you have any doubts about the stability or structural integrity of your stock, DO NOT joint it!

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

SECTION 2: CIRCUIT REQUIREMENTS

220V Single-Phase Operation

⚠WARNING

Serious personal injury could occur if you connect the machine to power before completing the setup process. DO NOT connect the machine to the power until instructed later in this manual.

⚠WARNING

Electrocution or fire could result if machine is not correctly grounded or connected to the power source. Get help if you do not know what you are doing.

Full Load Amperage Draw

This machine draws the following amps under maximum load:

Amp Draw..... 15 Amps

Power Supply Circuit Requirements

The power supply circuit for your machine MUST be grounded and rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

Minimum Circuit Size.....20 Amps

Power Connection Device

The type of plug required to connect your machine to power depends on the type of service you currently have or plan to install. We recommend using the plug shown in **Figure 1**.

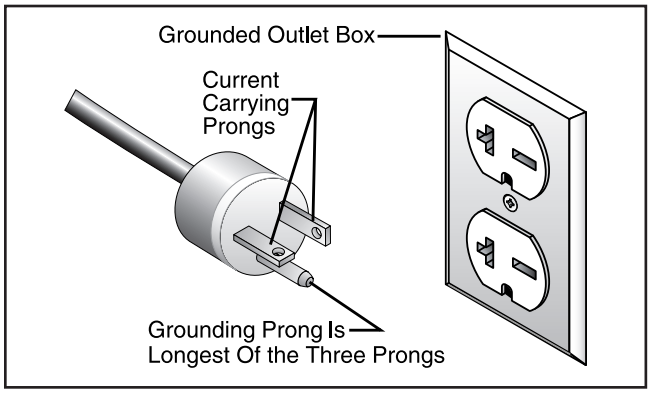


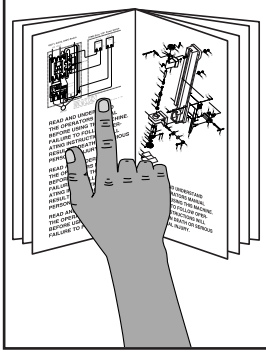
Figure 1. NEMA 6-20 plug and receptacle.

Extension Cords

Using extension cords may reduce the life of the motor. Instead, place the machine near a power source. If you must use an extension cord:

- Use at least a 12 gauge cord that does not exceed 50 feet in length!
- The extension cord must also have a ground wire and plug pin.
- A qualified electrician MUST size cords over 50 feet long to prevent motor damage.

SECTION 3: SETUP

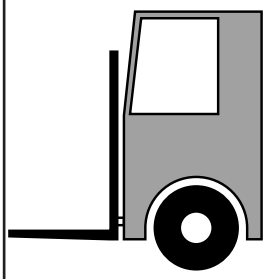


⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

The Model G0706 is a heavy machine (834 lbs shipping weight). Use power lifting equipment to lift this jointer. Otherwise serious personal injury may occur

Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Safety Glasses (for each person)	1
• Solvent	1
• Shop Rags for Cleaning	As Needed
• Extra Person for Lifting Help	1
• Fork Lift, Engine Hoist, or Boom Crane	1
• Lifting Straps (900 lb. Capacity)	2
• Straightedge (see **Page 33**)	1
• Phillips Screwdriver #2	1

Unpacking

Your machine was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.

Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Crate Contents: (Figure 2 & 3) **Qty**

A. Jointer Assembly 1
B. Fence Assembly 1
C. Cutterhead Guard 1
D. Cutterhead Guard Knob Bolt 1

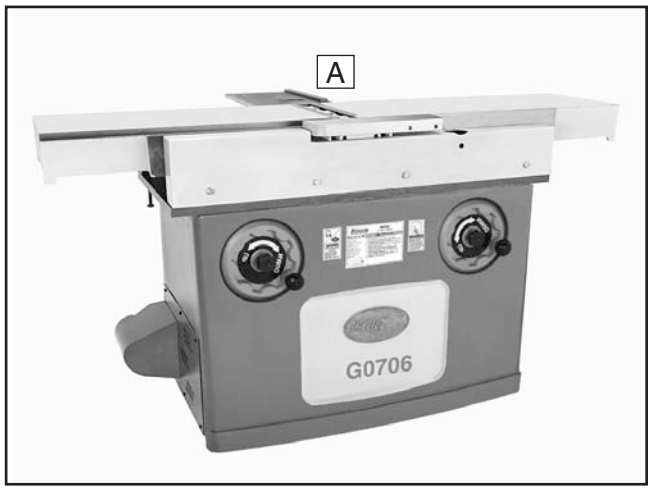


Figure 2. Crate contents.

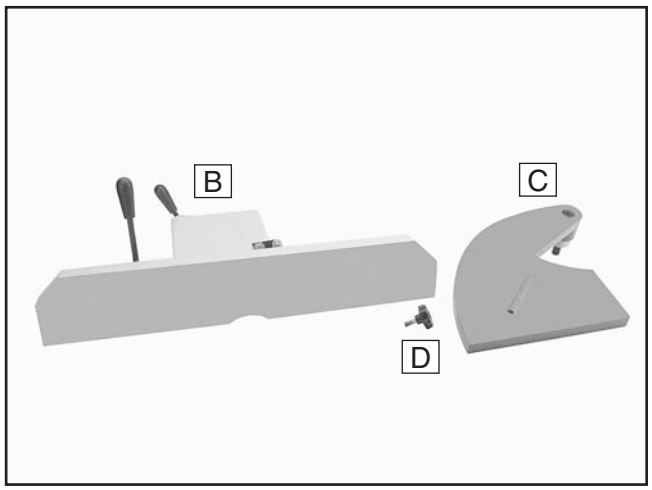


Figure 3. Fence, guard, and guard knob.

Hardware and Tools (Figure 4) **Qty**

- Flat Washers 10mm (Pedestal) 4
- Lock Washers 10mm (Pedestal) 4
- Cap Screws M10-1.5 x 25 (Pedestal) 4
- Push Blocks 2
- Open End Combo Wrench 8/10, 12/14, 17/19mm ..... 1 Each
- Hex Wrench 8mm 1
- T-Handle Hex Wrench 4mm 1
- Spiral Cutterhead Kit 1
  —Carbide Inserts 14 x 14 x 2 5
  —Flat Hd Torx Screws T20 M6-1 x 15 3
  —L-Wrench Torx T20 2
  —Driver Bit Torx T20 2

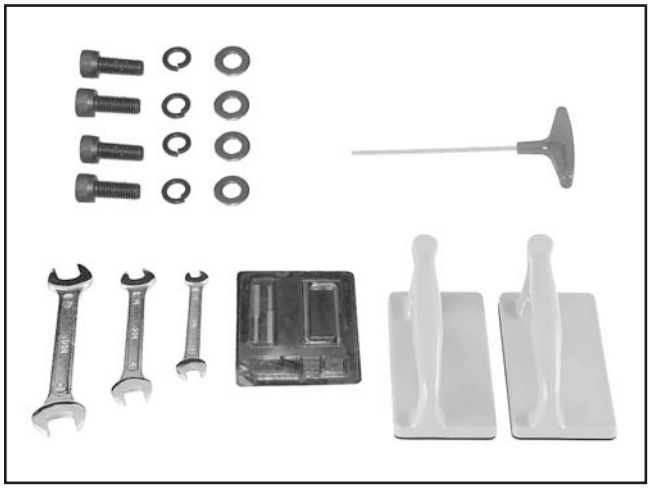
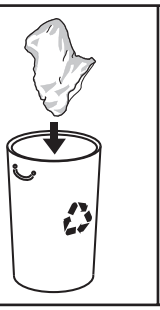


Figure 4. Hardware and tools.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

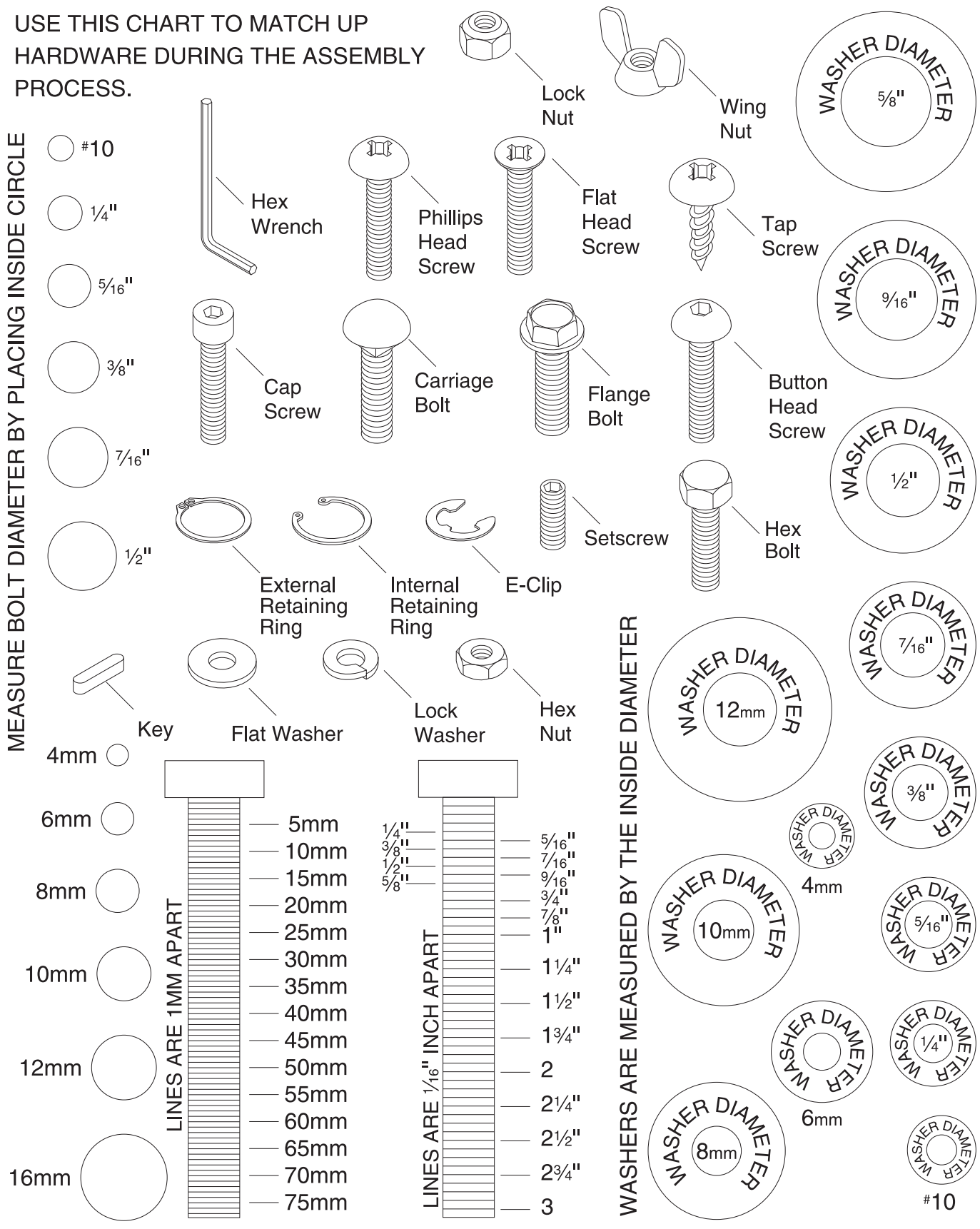


⚠WARNING

SUFFOCATION HAZARD!

Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

Hardware Recognition Chart



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage.

This rust preventative has been your machine's close ally and guardian since it left the factory. If your machine arrived to you free of rust, then be thankful that the rust preventative protected it during its journey...and try to stay thankful as you clean it off, because it can be challenging to remove if you are unprepared and impatient.

Plan on spending some time cleaning your machine. The time you spend doing this will reward you with smooth sliding parts and a better appreciation for the proper care of your machine's unpainted surfaces.

Although there are many ways to successfully remove the rust preventative, these instructions walk you through what works well for us.

Before cleaning, gather the following:
- Disposable Rags
- Cleaner/degreaser (see below)
- Safety glasses & disposable gloves

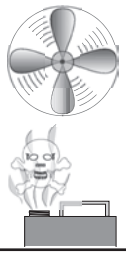
H9692—Orange Power Cleaner & Degreaser
One of the best cleaners we've found for quickly and easily removing rust preventative.

Figure 5. Model H9692 Industrial Orange Power Cleaner/Degreaser (99.9% biodegradable).

Note: *In a pinch, automotive degreasers, mineral spirits or WD•40 can be used to remove rust preventative. Before using these products, though, test them on an inconspicuous area of your paint to make sure they will not damage it.*

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.



⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

Basic steps for removing rust preventative:

1. Put on safety glasses and disposable gloves.

2. Coat all surfaces that have rust preventative with a liberal amount of your cleaner/degreaser and let them soak for few minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily.

   Note: *To clean off thick coats of rust preventative on flat surfaces, such as tables, use a PLASTIC paint scraper to scrape off the majority of the coating before wiping it off with your rag. (Do not use a metal scraper or you may scratch your machine.)*

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

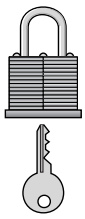
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

The physical environment where your machine is operated is important for safe operation and the longevity of its components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

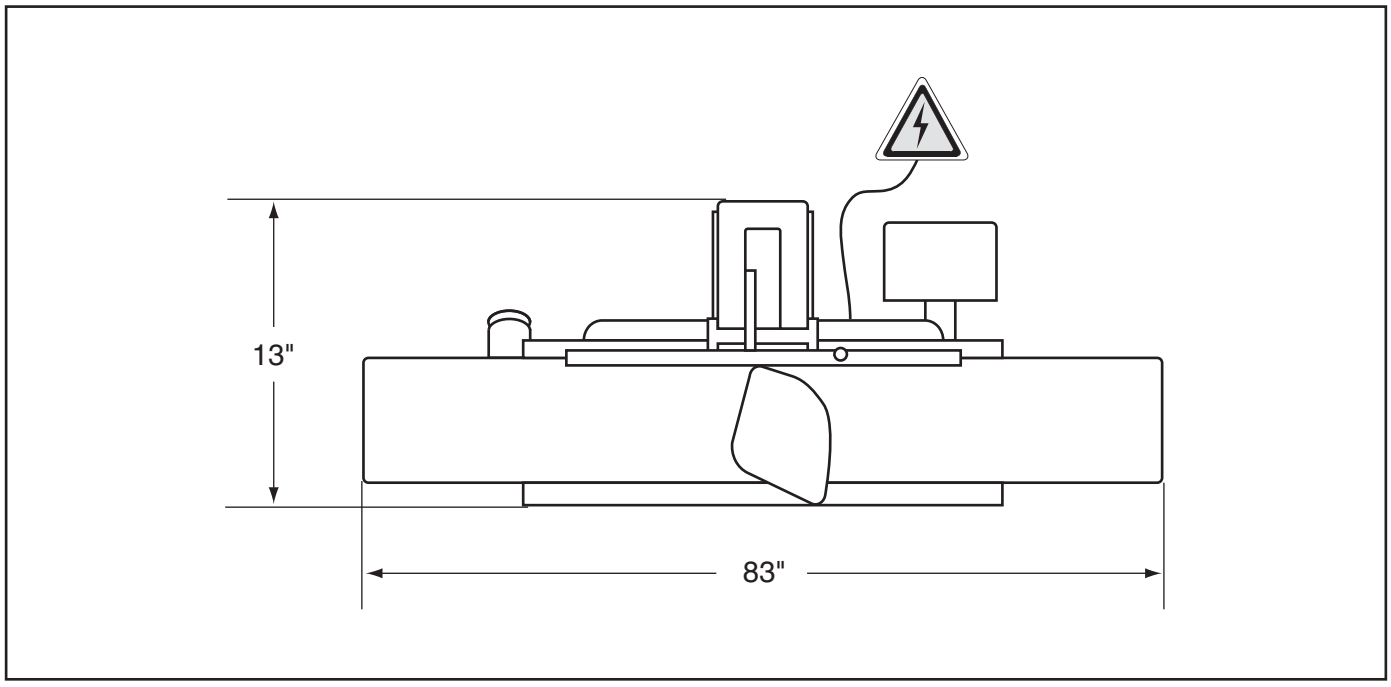
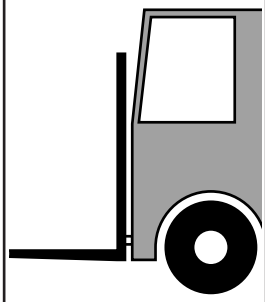


Figure 6. Minimum working clearances.

Moving & Placing Base Unit



⚠WARNING

The Model G0706 is a heavy machine. Serious personal injury may occur if safe moving methods are not used. To be safe, get assistance and use power equipment to move the shipping crate and remove the machine from the crate.

The Model G0706 requires the use of lifting equipment such as a forklift, engine hoist, or boom crane. DO NOT attempt to lift the machine by hand. Before lifting the jointer, make sure to unbolt the machine from the pallet.

To lift the jointer:

1. Wrap lifting straps around the infeed and outfeed tables. Position the straps as close to the base as possible to prevent damaging the tables.

2. With lifting straps positioned evenly, lift the jointer (**Figure 7**) off of the pallet and onto the floor.

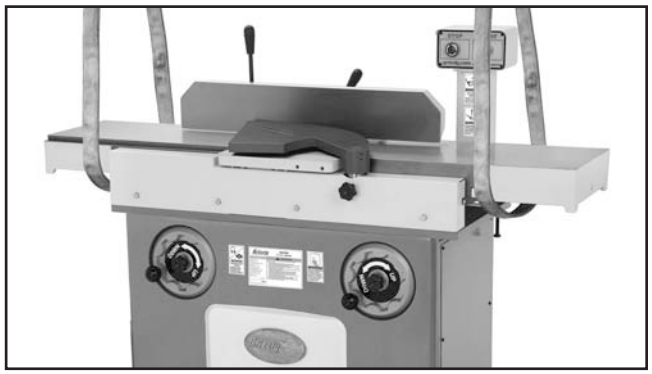


Figure 7. Model G0706 supported evenly by two lifting straps.

Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor or mount it on machine mounts. Both options are described below. Whichever option you choose, it is necessary to level your machine with a precision level.

Bolting to Concrete Floors

Lag shield anchors with lag bolts and anchor studs (**Figure 8**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

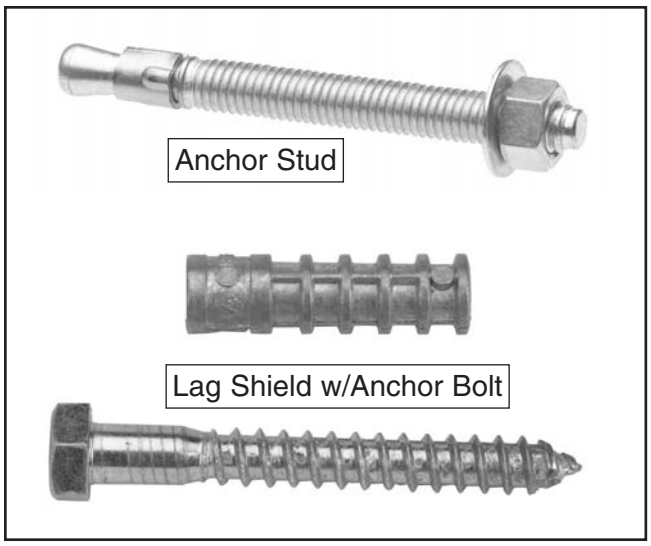


Figure 8. Typical fasteners for mounting to concrete floors.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

Assembly

Before starting the assembly process, make sure the fence, carriage, and table have been thoroughly cleaned of all the export grease. This will make the assembly process much cleaner and easier.

To assemble the jointer:

1. Remove the mounting spacers that hold the control panel pedestal to the jointer in the upside down shipping position. Set the two spacers and hex bolts aside for later use if you ever need to transport the jointer.

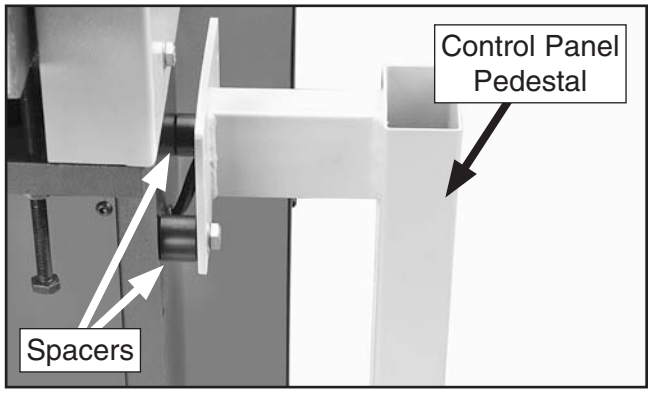


Figure 9. Control panel pedestal mounted upside down for shipping.

2. Mount the pedestal in the upright position using the four M10-1.5 x 25 cap screws, 10mm lock washers, and 10mm flat washers (see **Figure 10**). Use an 8mm hex wrench to tighten the cap screws.

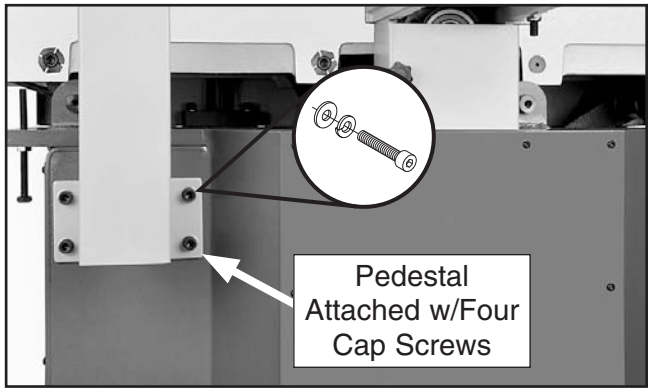


Figure 10. Control panel pedestal mounted in upright position.

3. Open the hinged pulley cover at the back of the machine to gain access to the cutterhead pulley (see **Figure 11**).

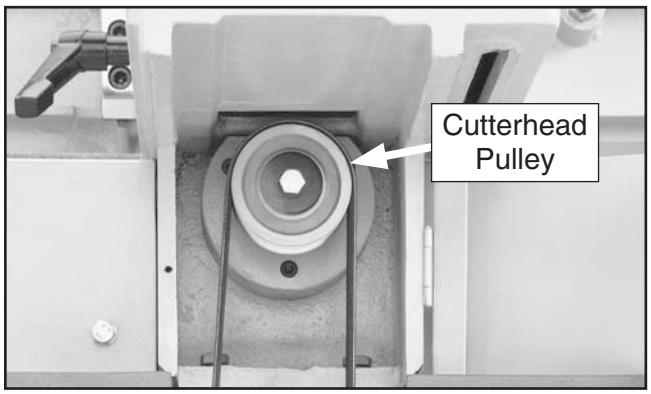


Figure 11. Cutterhead pulley behind hinged cover.

4. Use the cutterhead pulley to rotate the cutterhead until one of the cutter edges at the front end of the cutterhead is at the highest point of rotation or top dead center (see **Figure 12**).

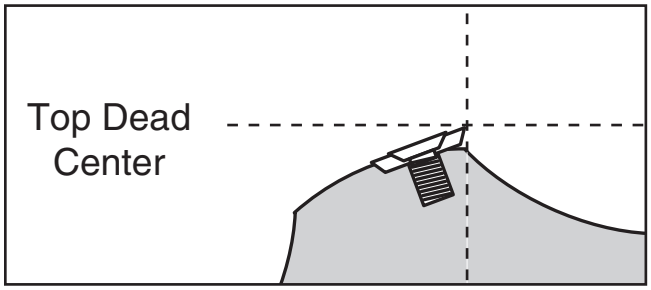


Figure 12. Cutter insert at top dead center.

5. Place a straightedge across the outfeed table and just over the cutter positioned at top dead center (the straightedge should not extend over the infeed table during this procedure; see **Figure 13**).

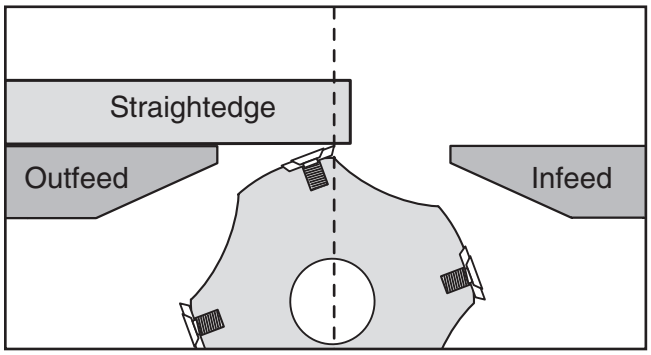


Figure 13. Outfeed table even with cutter at top dead center.

The outfeed table should be even with the cutter edge while it is at its highest point of rotation. If it is, repeat this step with one of the inserts at the other end of the cutterhead.

—If the outfeed table height is correct during both checks in the step above, then it is adjusted to the correct height. Make sure the handwheel lock is applied and move onto the next step.

—If the outfeed table height is not correct during both checks in the step above, then perform the procedure given in **Setting Outfeed Table Height** on **Page 33**.

⚠CAUTION

The outfeed table height MUST be set level with the cutting inserts when they are at top-dead-center or the workpiece cannot safely feed across the jointer, which will increase the risk of a kickback injury.

6. Install the cutterhead guard by sliding the post into the receptacle on the front of the machine (see **Figure 14**), adjust the guard height approximately ⅛" over the outfeed table, and tighten the knob.

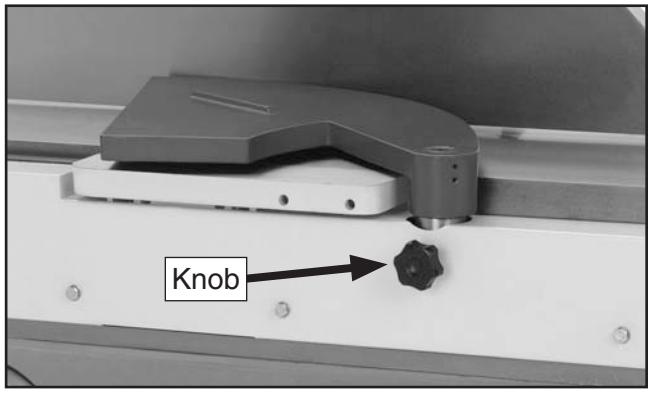


Figure 14. Cutterhead guard installed.

7. Rotate the cutterhead guard counterclockwise 1–2 turns to develop spring tension, then block it out of the way of the area where the fence will be installed.

8. Install the fence by fitting the keyway over the key on the mounting bracket. Use the hex nut and flat washer that were pre-installed in the fence lock handle threads to tighten the fence to the mounting bracket, as shown in **Figure 15**. Use a 19mm wrench to tighten the hex nut.

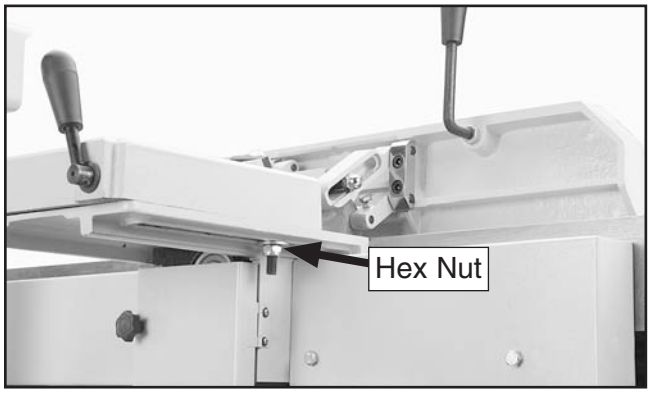


Figure 15. Fence installed on mounting bracket.

9. Position the fence even with the back-end of the cutterhead, then unblock the cutterhead guard so it can spring against the fence.

10. Test the guard operation by pulling it back enough to expose the entire cutterhead, then releasing it. The cutterhead guard must quickly spring against the face of the fence when moved out of the way and then released.

—If the cutterhead springs back against the fence when tested, then it is installed correctly. No further adjustments are needed and assembly is complete.

—If the cutterhead does not spring back against the fence, or it moves very slowly, then the spring tension is not great enough and the guard is not working properly. To fix this, remove the fence, then repeat **Steps 7–10** again but rotating the guard an additional turn counterclockwise during **Step 7**.

Congratulations! The jointer assembly is now complete.

Dust Port

⚠CAUTION

DO NOT operate the Model G0706 without an adequate dust collection system. This machine creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Dust Port:.....615 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must take into account many variables, including the CFM rating of the dust collector, the length of hose between the dust collector and the machine, the amount of branches or wyes, and the amount of other open lines throughout the system. Explaining this calculation is beyond the scope of this manual. If you are unsure of your system, consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit a 5" dust hose over the dust port then secure it in place with a hose clamp.

2. Tug the hose to make sure it does not come off. **Note:** *A tight fit is necessary for proper performance.*

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly. If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 31**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Connect the machine to the power source.

2. Twist the STOP button so it pops out.

3. Make sure you have read the safety instructions at the beginning of the manual, the machine is setup properly, and all tools and objects used during setup are cleared away from the machine.

4. Turn the machine ***ON*** and observe the operation of the machine. The machine should run smoothly with little or no vibration or rubbing noises.

   —Immediately turn the jointer ***OFF*** if you suspect any problems, and refer to **Page 31** to troubleshoot/fix before continuing with the next step. If the source of an unusual noise or vibration is not readily apparent, contact our Technical Support.

5. Press the STOP button in fully, then attempt to start the jointer without resetting the STOP button (leave the STOP button in the depressed position and press the START button).

   —If the jointer DOES NOT start with the STOP button in the depressed position, then the STOP button safety mechanism is working properly and the jointer is ready for normal operations.

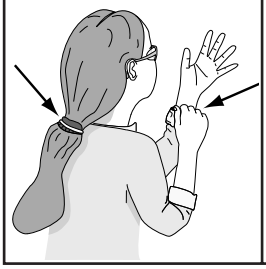
   —If the jointer DOES start, then the STOP button safety mechanism is not working properly; contact our Technical Support before further operating the jointer.

SECTION 4: OPERATIONS

⚠WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.





⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Operation Overview

This overview gives you the basic process that happens during an operation with this machine. Familiarize yourself with this process to better understand the remaining parts of the **Operation** section.

To complete a typical operation, the operator does the following:

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the fence tilt, if necessary, to the correct angle.
3. Adjusts the fence, if necessary, to accommodate the width of the workpiece, then locks the fence in place so it cannot move during operation.
4. Adjusts the infeed table height, if necessary, to control the depth of the initial cut.
5. Wears safety glasses, respirator, and ear protection, and locates the push blocks.
6. Starts the machine.
7. Using the push blocks, holds the workpiece firmly and flatly against both the infeed table and fence, and then pushes the workpiece past the cutterhead at a steady and controlled rate until the workpiece moves completely beyond the cutterhead.
8. Repeats **Step 7** until satisfied with the results.
9. Stops the machine.

Basic Controls

This section covers the basic operational controls of the jointer.

START Button: Starts motor only if the STOP button is in the out position (**Figure 16**).

STOP Button: Stops motor when pushed in and disables the START button. Enable the START button by twisting the STOP button until it pops out.

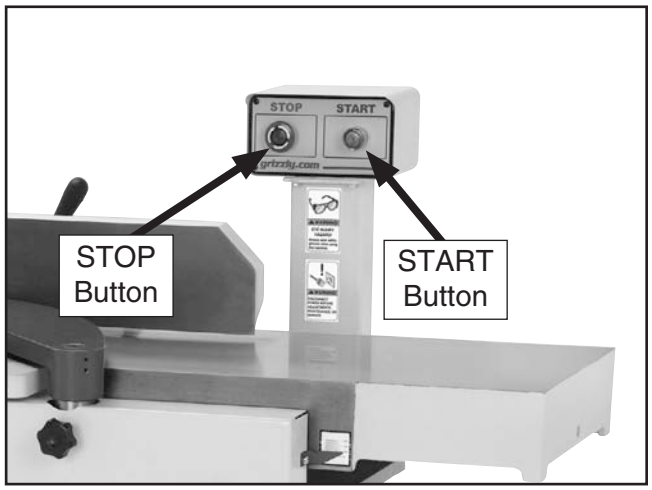


Figure 16. START/STOP buttons.

Table Height: To adjust the table height, loosen the table lock knob (**Figure 17**) and rotate the handwheel. Tighten the table lock knob to keep the handwheel and table in a fixed position. Both tables are equipped with stop bolts, so their range of movement may be limited to the setting of those stop bolts. To adjust the stop bolts, refer to the appropriate sub-sections in **SECTION 7: SERVICE**, starting on **Page 31**.

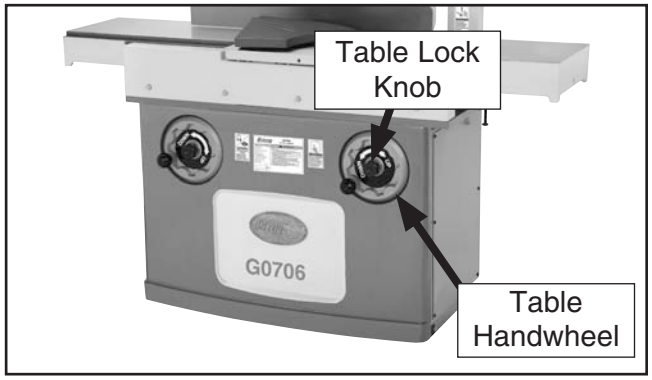


Figure 17. Table control locations.

Fence Movement: The fence has a lock handle that keeps it in position (**Figure 18**). To move the fence, loosen the lock handle and slide the fence where needed.

Fence Tilting: The tilt lock (**Figure 18**) secures the fence at any position in the available range. The stop block allows the fence tilt to quickly be set at 90°. Stop bolts block the fence at 45° inward and 45° outward, for common 45° bevel cuts. Even when the fence is resting against the stop bolts, the tilt lock must be tightened before cutting.

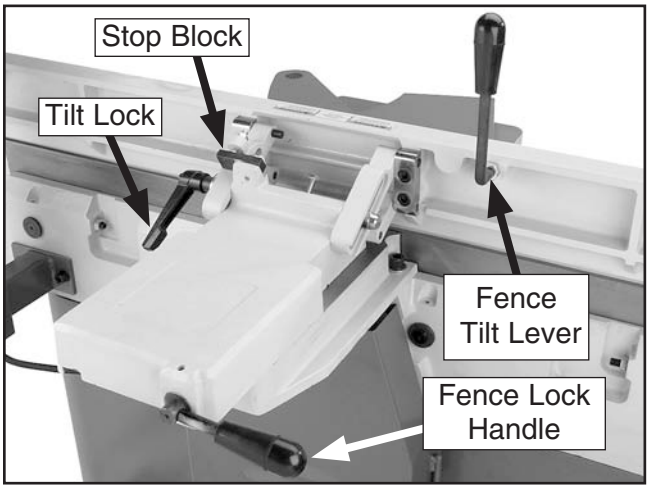


Figure 18. Fence lock, tilt lock and stop block locations.

Stock Inspection & Requirements

Follow these rules when choosing and jointing stock:

- **DO NOT joint or surface place stock that contains large or loose knots.** Injury to the operator or damage to the workpiece can occur if a knot becomes dislodged during the cutting operation.

- **Jointing and surface planing with the grain is safer for the operator and produces a better finish.** Cutting against the grain increases the likelihood of kickback and workpiece tear-out. DO NOT cut against the grain! Cutting with the grain is feeding the stock across the cutterhead so the grain points down and back, as viewed from the front edge of the stock (see **Figure 19**).

  Note: *If the grain changes direction along the edge of the workpiece, decrease the depth of cut and make additional passes.*

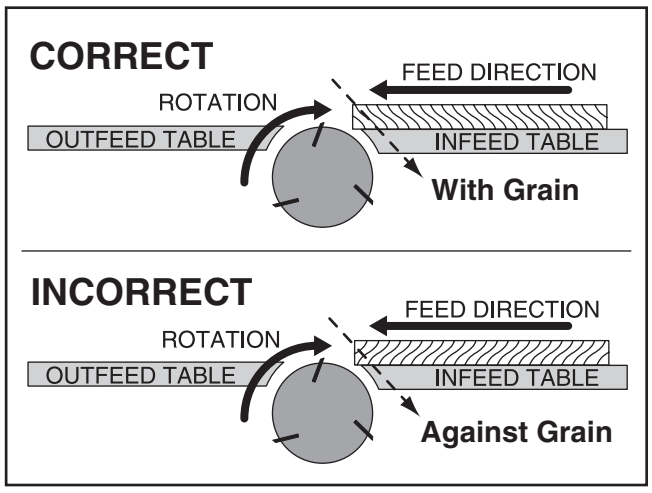


Figure 19. Proper grain alignment with the cutterhead.

- **Only process natural wood fiber through your jointer.** Your jointer is designed to cut only natural wood stock. This machine is NOT designed to cut metal, glass, stone, tile, products with lead-based paint, or products that contain asbestos—cutting these materials with a jointer may lead to injury.

- **Scrape all glue off the workpiece before jointing.** Glue deposits on the workpiece, hard or soft, will gum up the cutterhead and produce poor results.

- **Remove foreign objects from the workpiece.** Make sure that any stock you process with the jointer is clean and free of dirt, nails, staples, tiny rocks or any other foreign objects, that could damage the cutterhead. These particles could also cause a spark as they strike the cutterhead and create a fire hazard.

  Note: *Wood stacked on a concrete or dirt surface can have small pieces of concrete or stone pressed into the surface.*

- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the inserts and poor cutting results. Excess moisture can also hasten rust and corrosion.

- **Make sure your workpiece exceeds the minimum dimension requirements, as shown in Figure 20, before processing it through the jointer, or the workpiece may break or kickback during the operation.**

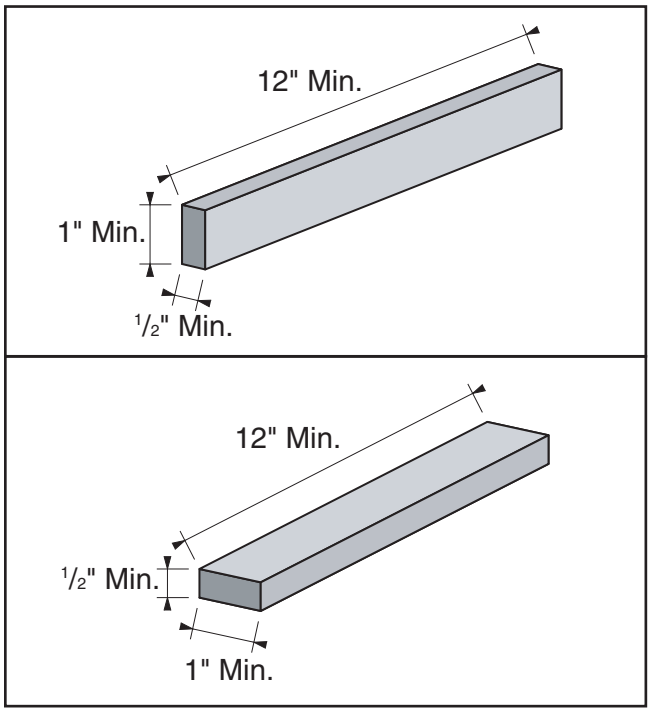


Figure 20. Minimum stock dimensions for the jointer.

Squaring Stock

Squaring stock involves four steps performed in the following order:

1. **Surface Plane on the Jointer:** The concave face of the workpiece is surface planed flat with the jointer (see **Figure 21**).

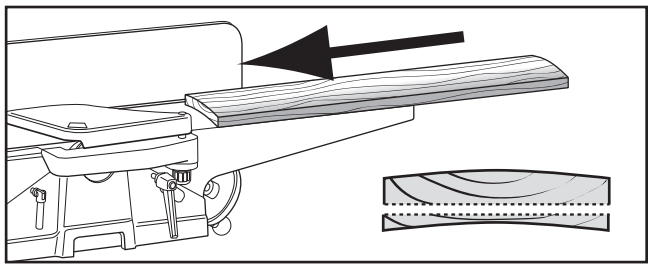


Figure 21. Surface planing on the jointer.

2. **Surface Plane on a Thickness Planer:** The opposite face of the workpiece is surface planed flat with a thickness planer (see **Figure 22**).

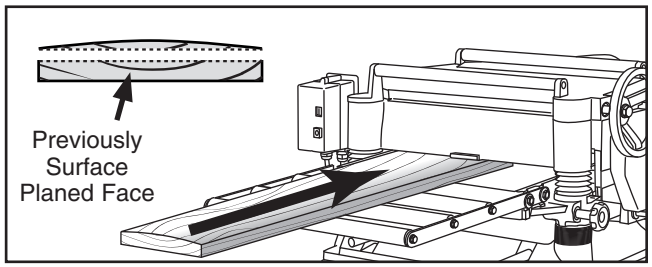


Figure 22. Surface planing on a thickness planer.

3. **Edge Joint on the Jointer:** The concave edge of the workpiece is jointed flat with the jointer (see **Figure 23**).

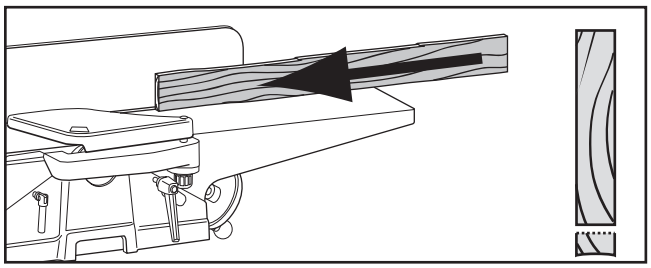


Figure 23. Edge jointing on the jointer.

4. **Rip Cut on a Table Saw:** The jointed edge of the workpiece is placed against the table saw fence and the opposite edge is cut off (see **Figure 24**).

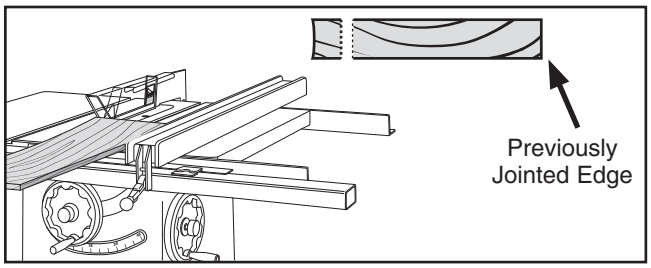


Figure 24. Rip cutting on a table saw.

⚠WARNING

Making adjustments to the jointer while the machine is *ON* greatly increases the risk to the operator from the rotating cutterhead. ALWAYS make sure the jointer is *OFF* and disconnected from power before performing adjustments, maintenance, or service on the machine!

Surface Planing

The purpose of surface planing on the jointer is to make one face of the workpiece flat (see **Figures 25–26**). This is a necessary step when squaring a workpiece for a thickness planer.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0" and practice feeding the workpiece across the tables as described for each of the jointing procedures. This process will better prepare you for the actual operation.

Figure 25. Example of surface planing with the jointer.

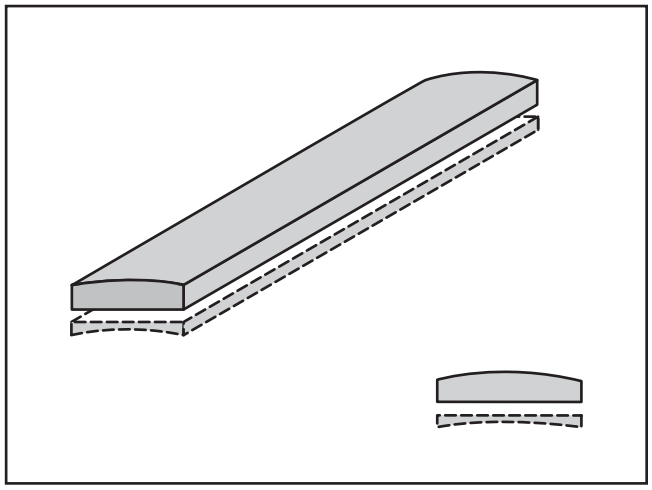


Figure 26. Illustration of surface planing results.

To surface plane the workpiece on the jointer:

1. DISCONNECT JOINTER FROM POWER!

2. Make sure you read and follow the **Safety Instructions** beginning on **Page 6** and the **Stock Inspection & Requirement** rules beginning on **Page 21**.

3. Verify that the outfeed table height is properly set (refer to **Setting Outfeed Table Height** on **Page 33** for detailed instructions).

4. Set the depth of cut for your operation and the fence to 90°.

   Note: *We suggest a 1/32" depth of cut for surface planing, and a more shallow depth for hardwood species or for wide stock.*

5. If your workpiece is cupped or warped, place it so the concave side is face down on the infeed table.

6. Connect the jointer to power and turn it ***ON***.

⚠WARNING

Failure to use push blocks when surface planing could result in your hands contacting the rotating cutterhead, which will cause serious personal injury. ALWAYS use push blocks when surface planing on the jointer!

7. With a push block in each hand, press the workpiece against the infeed table and the fence with firm pressure, then feed the workpiece over the cutterhead.

   Note: *When your leading hand comes within 4" of the cutterhead, lift that push block up and place it on the workpiece portion that is on the outfeed table. Now, focus the downward pressure with the leading hand while feeding, then repeat the same action with your trailing hand when it comes within 4" of the cutterhead. Keep your hands safe! DO NOT allow them to get any closer than 4" from the cutterhead.*

8. Repeat **Step 7** until the entire workpiece surface is flat.

Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged workpiece surface that is suitable for joinery or finishing (see **Figures 27–28**). It is also a necessary step when squaring rough or warped stock.

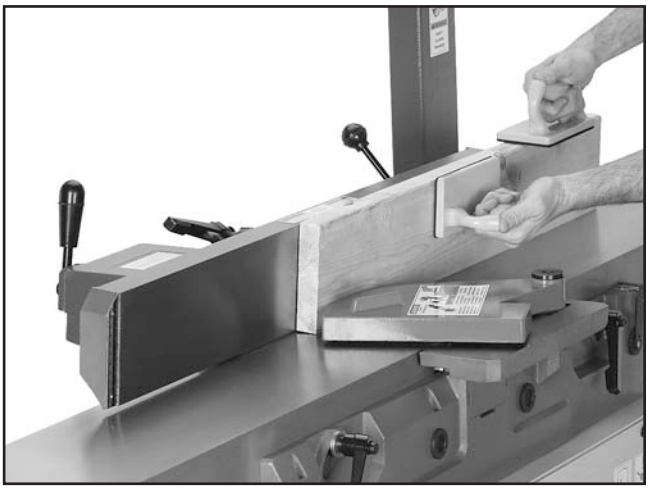


Figure 27. Example of edge jointing operation.

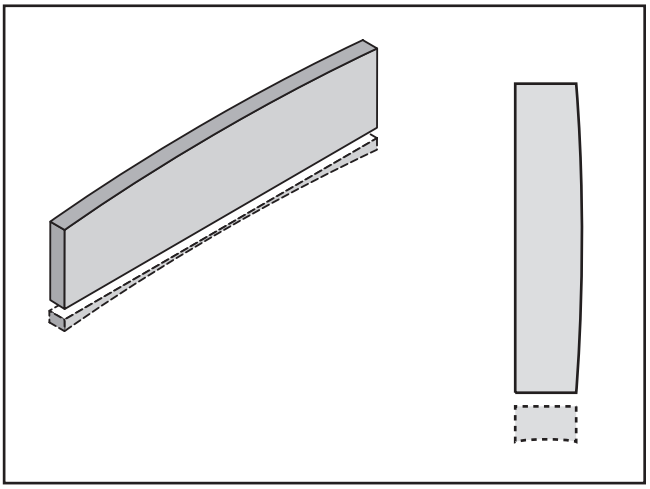


Figure 28. Illustration of edge jointing results.

To edge joint on the jointer:

1. DISCONNECT JOINTER FROM POWER!

2. Make sure you read and follow the **Safety Instructions** beginning on **Page 6** and the **Stock Inspection & Requirement** rules beginning on **Page 21**.

3. Verify that the outfeed table height is properly set (refer to **Setting Outfeed Table Height** on **Page 33** for detailed instructions).

4. Set the depth of cut for your operation and the fence to 90°.

   Note: *We suggest 1/16"–1/8" depth of cut for edge jointing, and a more shallow depth for hardwood species or for wide stock.*

5. If your workpiece is cupped or warped, place it so the concave side is face down on the infeed table.

6. Connect the jointer to power and turn it ***ON***.

7. With a push block in each hand, press the workpiece against the infeed table and the fence with firm pressure, then feed the workpiece over the cutterhead.

   Note: *When your leading hand comes within 4" of the cutterhead, lift that push block up and place it on the workpiece portion that is on the outfeed table. Now, focus the downward pressure with the leading hand while feeding, then repeat the same action with your trailing hand when it comes within 4" of the cutterhead. Keep your hands safe! DO NOT allow them to get any closer than 4" from the cutterhead.*

8. Repeat **Step 7** until the entire workpiece edge is flat.

Bevel Cutting

The purpose of bevel cutting on the jointer is to cut the workpiece edge at a specific angle (see **Figures 29–30**).

Your jointer has fence stops that can be set at 90° or 45°. If your operation requires a different angle, the fence can be locked in place anywhere between these angles.

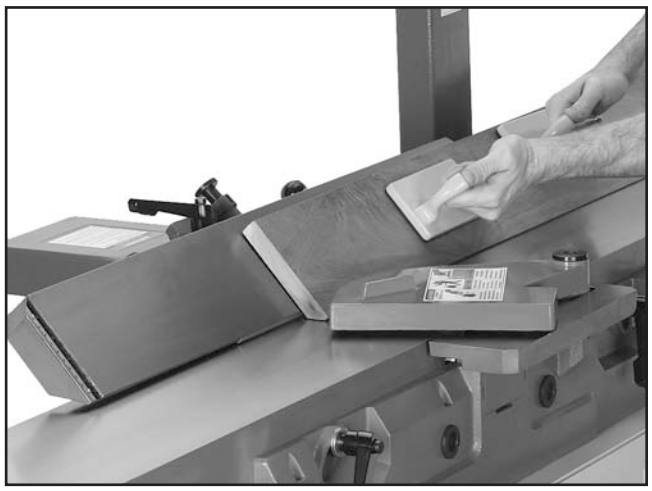


Figure 29. Fence setup for a bevel cut of 45°.

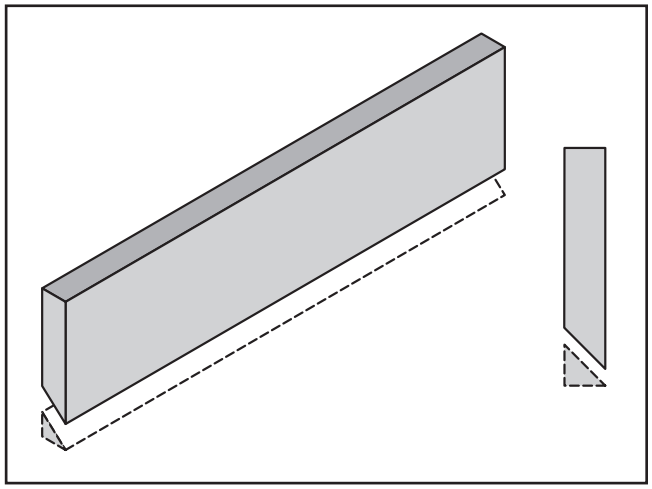


Figure 30. Illustration of bevel cutting results.

To bevel cut on the jointer:

1. DISCONNECT JOINTER FROM POWER!

2. Make sure you read and follow the **Safety Instructions** beginning on **Page 6** and the **Stock Inspection & Requirement** rules beginning on **Page 21**.

3. Verify that the outfeed table height is properly set (refer to **Setting Outfeed Table Height** on **Page 33** for detailed instructions).

4. Set the depth of cut for your operation and the fence to the required angle.

   Note: *We suggest 1/16"–1/8" depth of cut for bevel cutting, and a more shallow depth for hardwood species or for wide stock.*

5. If your workpiece is cupped or warped, place it so the concave side is face down on the infeed table.

6. Connect the jointer to power and turn it ***ON***.

7. With a push block in each hand, press the workpiece against the infeed table and the fence with firm pressure, then feed the workpiece over the cutterhead.

   Note: *When your leading hand comes within 4" of the cutterhead, lift that push block up and place it on the workpiece portion that is on the outfeed table. Now, focus the downward pressure with the leading hand while feeding, then repeat the same action with your trailing hand when it comes within 4" of the cutterhead. Keep your hands safe! DO NOT allow them to get any closer than 4" from the cutterhead.*

8. Repeat **Step 7** until the bevel cut is satisfactory.

Rabbet Cutting

The purpose of rabbet cutting is to remove a section of the workpiece edge (see **Figures 31-32**). When combined with another rabbet-cut edge, the rabbet joints create a simple, yet strong method of joining stock.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.

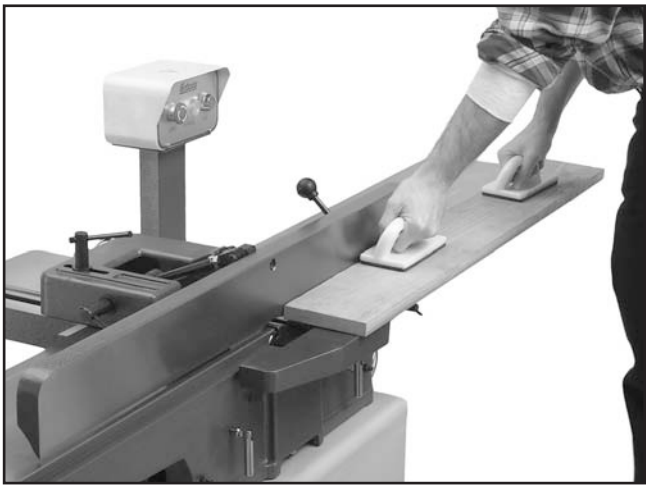


Figure 31. Typical rabbet cutting operation.

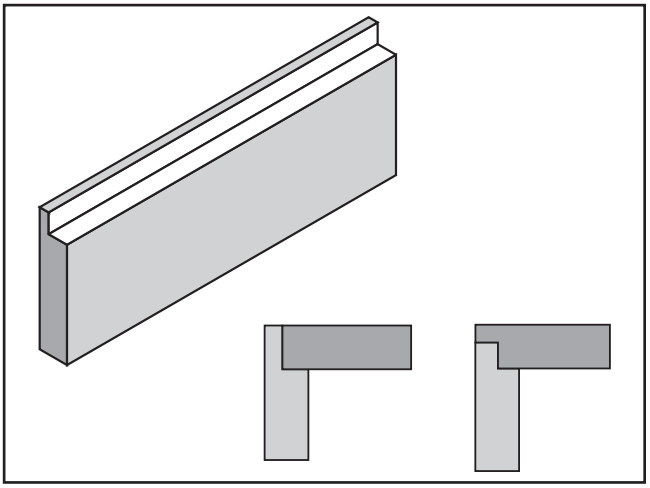


Figure 32. Illustration of rabbet cutting effects and a few sample joints.

To rabbet cut on the jointer:

1. DISCONNECT JOINTER FROM POWER!

2. Read and understand **SECTION 1: SAFETY,** beginning on **Page 6**.

3. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 21**.

4. Set the cutting depth for your operation. We recommend between 1/16" and 1/8" for rabbet cutting.

⚠WARNING

When the cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes the operator to the moving cutterhead. Always replace the cutterhead guard after rabbet cutting!

5. Remove the cutterhead guard.

6. Set the fence to 90°, then move it forward so the amount of cutterhead exposed is the same as the size of your rabbet

7. Connect the jointer to power and turn it ***ON***.

8. With a push block in each hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.

   Note: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

9. Repeat **Step 8** until the your rabbet is cut to depth.

Cutterhead Inserts

The Model G0706 spiral cutterhead is equipped with indexable carbide inserts that can be rotated to reveal any one of four cutting edges. If one edge of the insert becomes dull or damaged, rotate it 90° to reveal a fresh cutting edge, as shown in **Figure 33**.

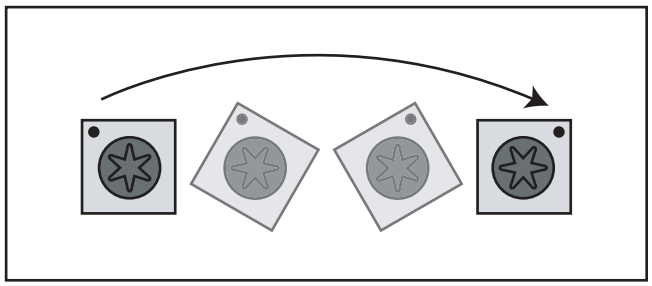


Figure 33. Insert rotating sequence.

Tools Needed	**Qty**
Driver w/T-20 Torx Bit	1
Precision Straightedge	1

To rotate or replace a spiral cutterhead insert:

1. DISCONNECT JOINTER FROM POWER!

2. Put on heavy leather or Kevlar gloves to protect your fingers and hands.

3. Remove any sawdust or debris from the head of the Torx screw, the insert, and the surrounding area. A shop vacuum can make this an easy task and keep your fingers away from the sharp inserts.

4. Remove the Torx screw and the insert, then clean all dust and debris from both parts and the pocket they were removed from.

   Note: *Proper cleaning of the insert, Torx screw, and the cutterhead pocket is critical to achieving a smooth finish. Dirt or dust trapped between the insert and cutterhead will raise the insert slightly and make noticeable marks on your workpiece the next time you cut.*

   Tip: *Use low-pressure compressed air or a vacuum nozzle to clean out the cutterhead pocket.*

5. Replace the insert so that a fresh cutting edge faces outward.

   —If all four insert cutting edges have been used, replace it with a new one. Always position the reference dot in the same position when installing a new insert to aid in the rotational sequencing.

6. Lubricate the Torx screw threads with a small amount of light machine oil, wipe the excess off, and torque the screw to approximately 50–55 inch/pounds.

7. Position the straightedge on the outfeed table and over the insert to make sure that it is installed correctly and is at the same height as the other inserts.

   —If the insert is raised above the correct height, then it is either not fastened down correctly or there is too much oil under the insert. Remove the insert, clean away the excess oil, and reinstall it. Make sure the insert screw is torqued as discussed in **Step 6**.

⚠WARNING

The outfeed table MUST be level with cutterhead inserts when they are at top dead center (their highest point during rotation). Otherwise, the workpiece cannot properly feed past the cutterhead, which may result in the workpiece kicking back and seriously injuring the operator.

8. Check the outfeed table, and re-set the outfeed table height as instructed in the **Setting Outfeed Table Height** on **Page 33**.

SECTION 5: ACCESSORIES

T21348—Carbide Indexable Insert, 10 Pk.
These indexable carbide inserts can be rotated to provide four factory sharp edges before replacement. 14mm x 14mm x 2mm.

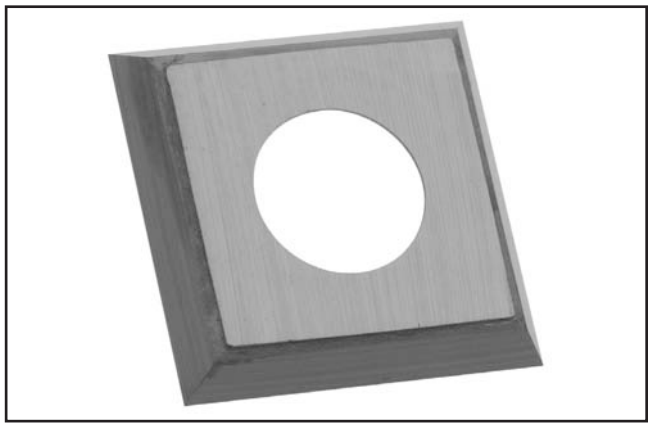


Figure 34. Carbide indexable insert for the spiral cutterheads.

T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20452—"Kirova" Anti-Reflective S. Glasses
T20451—"Kirova" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
H7194—Bifocal Safety Glasses 1.5
H7195—Bifocal Safety Glasses 2.0
H7196—Bifocal Safety Glasses 2.5

Figure 35. Eye protection assortment.

H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter Pair P100
Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!

Figure 36. Half-mask respirator with disposable cartridge filters.

H9291—12" Shelix Spiral Cutterhead
Made in the USA by Byrd®, these indexable carbide insert cutterheads are very well made and leave a great finish. The inserts are not only placed along a spiral pattern, they are also at an angle so that the shearing action leaves a glassy smooth cut on the toughest of woods. Each cutterhead comes with 5 extra replacement inserts.

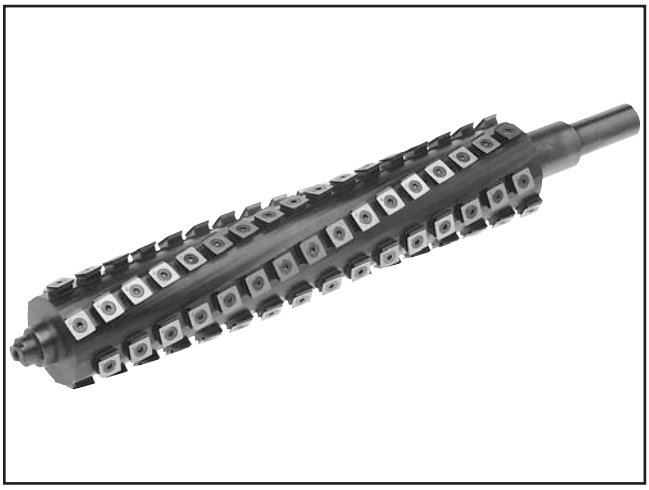


Figure 37. H9291 Spiral Cutterhead.

G9256—6" Dial Caliper
G9257—8" Dial Caliper
G9258—12" Dial Caliper
Required for jointing, planing, or sanding to critical tolerances. These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display. An absolute treat for the perfectionist!

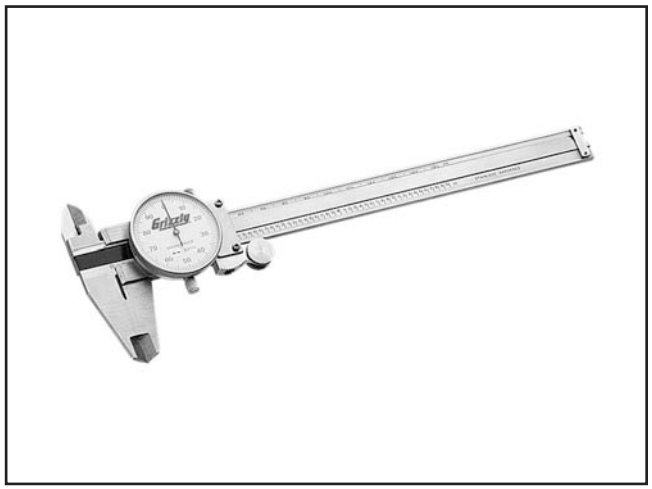


Figure 38. Grizzly® Dial Calipers.

G1029Z2—2HP Dust Collector
The great combination of price and performance make this one of the most popular dust collectors we sell. Perfect for use as a central dust collector in a small shop or as a "dedicated" dust collector next to an industrial machine. Features 220V single-phase power, 1550 CFM, 2.5 micron filtration, and a 6" main inlet w/included 4" x 2" "Y" fitting.

Figure 39. G1029Z2 2HP dust collector.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 40. Recommended products for protecting unpainted cast iron/steel part on machinery.

G9643—8" Precision Straightedge
G9644—12" Precision Straightedge
H2675—16" Precision Straightedge
Ideal for aligning your outfeed bed to the cutterhead and calibrating your depth scale. These grade 00 heavy-duty stainless steel straightedges are manufactured to DIN874 standards for professional results in set-up and inspection work.

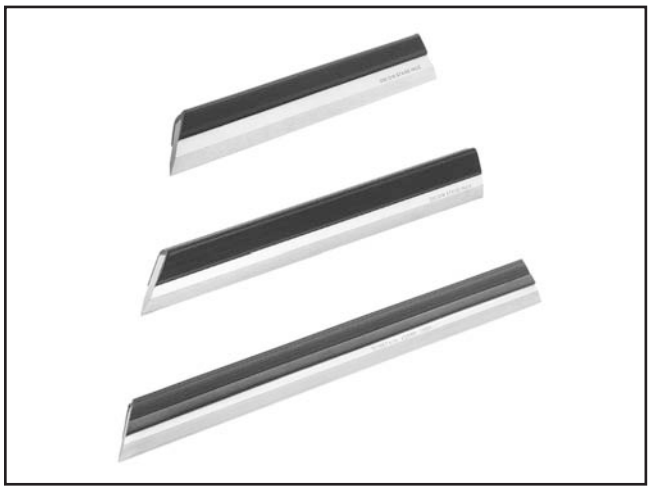
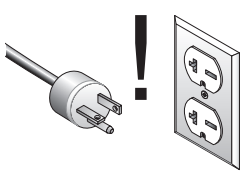


Figure 41. Straightedges.

SECTION 6: MAINTENANCE



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily
- Vacuum all dust on and around the machine.
- Wipe down the tables and all other unpainted cast iron with a metal protectant.

Monthly Check
- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off of motor.

Ribbed V-belt

To ensure optimum power transmission from the motor to the cutterhead, the ribbed V-belt must be in good condition (free from cracks, fraying and wear) and properly aligned and tensioned (refer to **Drive Belt** on **Page 42**).

Cleaning

Cleaning the Model G0706 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it.

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 29**).

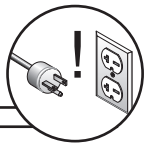
Lubrication

Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

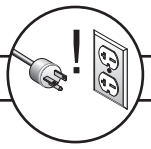
SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Symptom	Possible Cause	Possible Solution
Motor will not start.	1. STOP button depressed. 2. Thermal overload protection tripped in magnetic switch. 3. Low voltage. 4. Open circuit in motor or loose connections.	1. Twist the stop button to allow it to pop out. 2. Press the "Reset" button on the thermal overload relay, located inside the magnetic switch. 3. Check power line for proper voltage. 4. Inspect all lead connections on motor for loose or open connections.
Fuses or circuit breakers blow.	1. Short circuit in line cord or plug.	1. Repair or replace cord or plug for damaged insulation and shorted wires.
Motor overheats.	1. Motor overloaded during operation. 2. Air circulation through the motor restricted.	1. Reduce load on motor; take lighter cuts. 2. Clean off motor to provide normal air circulation.
Motor stalls or shuts off during a cut.	1. Motor overloaded during operation. 2. Thermal overload protection tripped in magnetic switch. 3. Short circuit in motor or loose connections. 4. Circuit breaker tripped.	1. Reduce load on motor; take lighter cuts. 2. Press the "Reset" button on the thermal overload relay, located inside the magnetic switch. 3. Repair or replace connections on motor for loose or shorted terminals or worn insulation. 4. Install correct circuit breaker; reduce # of machines running on that circuit (circuit overload).
Cutterhead slows when cutting or makes a squealing noise, especially on start-up.	1. V-belt loose. 2. V-belt worn out.	1. Tighten V-belt (**Page 42**). 2. Replace V-belt (**Page 42**).
Loud repetitious noise coming from machine.	1. Pulley set screws or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belt is damaged.	1. Inspect keys and set screws. Replace or tighten if necessary. 2. Adjust fan cover mounting position, tighten fan, or shim fan cover. 3. Replace V-belt (**Page 42**).
Vibration when running or cutting.	1. Loose or damaged cutter. 2. Damaged belt. 3. Worn cutterhead bearings.	1. Tighten or replace cutter. 2. Replace (**Page 42**). 3. Check/replace cutterhead bearings.
Tables are hard to adjust.	1. Table lock is engaged or partially engaged. 2. Table stops blocking movement.	1. Completely loosen the table lock. 2. Loosen/reset table stop bolts (**Pages 33 & 39**).
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).	1. Outfeed table is set too low. 2. Operator pushing down on trailing end of the workpiece.	1. Align outfeed table with cutterhead insert at top dead center (**Page 33**). 2. Reduce/eliminate downward pressure on that end of workpiece.



Symptom	Possible Cause	Possible Solution
Workpiece stops in the middle of the cut.	1. Outfeed table is set too high.	1. Align outfeed table with cutterhead insert at top dead center (**Page 33**).
Chipping marks in the workpiece.	1. Knots or conflicting grain direction in wood. 2. Nicked or chipped inserts. 3. Feeding workpiece too fast. 4. Taking too deep of a cut.	1. Inspect workpiece for knots and grain (**Page 21**); only use clean stock. 2. Rotate or replace the bad cutter (**Page 27**). 3. Slow down the feed rate. 4. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods.)
Fuzzy grain in workpiece.	1. Wood may have high moisture content or surface wetness. 2. Dull inserts.	1. Check moisture content and allow to dry if moisture is too high. 2. Rotate or replace the bad cutter (**Page 27**).
Long lines or ridges that run along the length of the board.	1. Nicked or chipped inserts.	1. Rotate or replace the bad cutter (**Page 27**).
Uneven cutter marks, wavy surface, or chatter marks across the face of the board.	1. Feeding workpiece too fast. 2. Inserts not adjusted at even heights in the cutterhead.	1. Slow down the feed rate. 2. Remove, clean, and reinstall any inserts that are "raised" in the cutterhead (**Page 27**).
Board edge is concave or convex after jointing.	1. Board not held with even pressure on infeed and outfeed table during cut. 2. Board started too uneven. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes.	1. Hold board with even pressure as it moves over the cutterhead. 2. Take partial cuts to remove the extreme high spots before doing a full pass. 3. Surface plane one face so there is a good surface to position against the fence. 4. It may take 3 to 5 passes to achieve a perfect edge, depending on the starting condition of the board and the depth of cut.

Outfeed Table Height

Checking Outfeed Table Height

The outfeed table height MUST be set even with the cutting inserts when they are at top-dead-center or the workpiece cannot safely feed across the jointer. The outfeed table height is factory set, but we recommend that you check it to make sure that it didn't change during shipping.

Tools Needed	Qty
Straightedge	1

To check the outfeed table height:

1. DISCONNECT JOINTER FROM POWER!

2. Open the hinged pulley guard at the back of the machine to gain access to the cutterhead pulley shown in **Figure 42**.

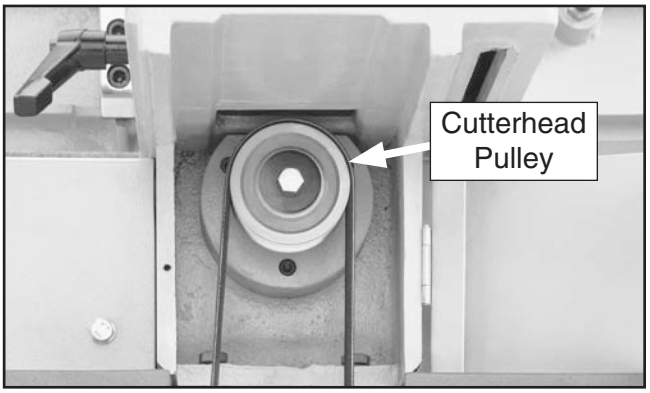


Figure 42. Cutterhead pulley.

3. Use the cutterhead pulley to rotate the cutterhead until one of the cutter edges at the front end of the cutterhead is at the highest point of rotation or top dead center (see **Figure 43**).

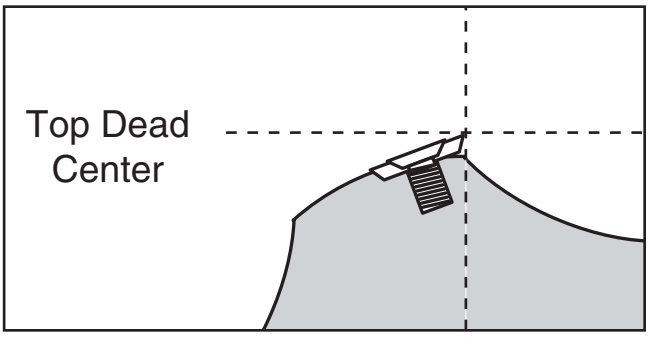


Figure 43. Cutter insert at top dead center.

4. Place a straightedge across the outfeed table and just over the cutter positioned at top dead center (the straightedge should not extend over the infeed table during this procedure; see **Figure 44**).

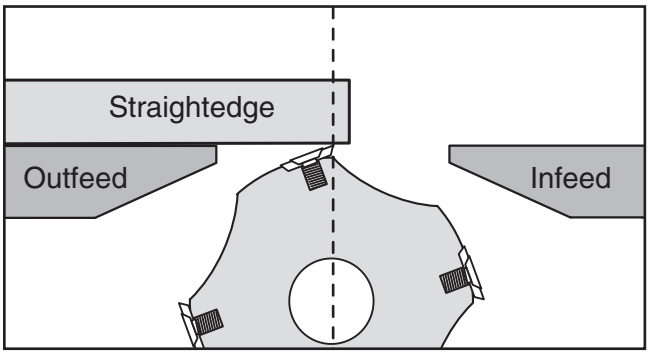


Figure 44. Outfeed table even with cutter at top dead center.

When correctly set, the cutter will barely touch the straightedge, as shown in **Figure 44**.

—If your outfeed table is correctly set, no adjustments are necessary.

—If the cutter lifts the straightedge off the table or it is below the straightedge, then the outfeed table height must be set. Continue to the next procedure **Setting Outfeed Table Height**.

Setting Outfeed Table Height

The outfeed table height must be even with the top of the cutterhead inserts. If the outfeed table is set too low, there will be snipe. If the outfeed table is set too high, the workpiece will hit the edge of the outfeed table during operation, increasing the chance of kickback.

The height of the outfeed table is controlled by the handwheel located on the front of the stand. The knob in the center of the handwheel locks the handwheel in position to keep it in place after adjustments and also unlocks the handwheel so it can be rotated to make adjustments. There is also a stop bolt on the underside of the table that can prevent the outfeed table from moving below a pre-set position.

Tools Needed	Qty
Straightedge	1
Wrench 12mm	1

To set the outfeed table height:

1. DISCONNECT JOINTER FROM POWER!

2. Remove the cutterhead guard and fence.

3. Loosen the outfeed table lock knob located in the center of the outfeed table handwheel.

4. Loosen the jam nut and stop bolt located under the outfeed table (see **Figure 45**). Make sure to back the stop bolt away from the area where it contacts the table. This will allow the table room to move during the adjustments in the following steps.

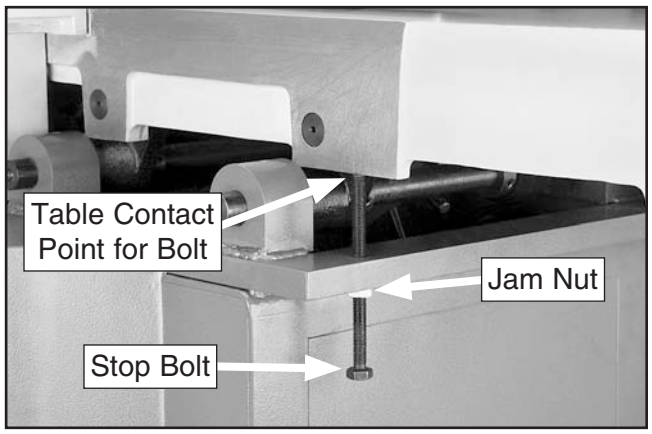


Figure 45. Outfeed table stop bolt.

5. Open the hinged cutterhead guard at the back of the machine to gain access to the cutterhead pulley shown in **Figure 42**.

6. Use the cutterhead pulley to rotate the cutterhead until one of the cutter edges at the front end of the cutterhead is at the highest point of rotation or top dead center (see **Figure 43**).

7. Place the straightedge on the outfeed table so it extends over the cutterhead.

8A. (Standard Procedure) Use the outfeed table handwheel to set the outfeed table height so that the cutting insert at top dead center barely touches the straightedge, as illustrated in **Figure 44**.

8B. (Optional Procedure) Some advanced woodworkers have found that they can virtually eliminate snipe by setting the outfeed table slightly lower than a cutter when it is at top dead center.

To set the outfeed table with this method:

a. Make two marks on the straightedge that are 5⁄32" apart.

b. Line up the first mark with the edge of the outfeed table (see **Figure 46**).

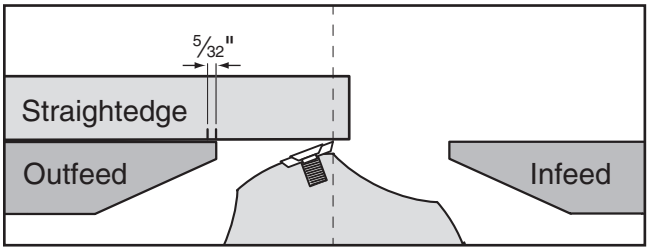


Figure 46. Lining up 1st mark on straightedge with edge of outfeed table.

c. Rotate the cutterhead clockwise by hand, watching how far the cutter drags the straightedge forward. Slightly adjust the outfeed table height until the cutter drags the straightedge forward enough to line up the second mark with the edge of the outfeed table, as shown in **Figure 47**.

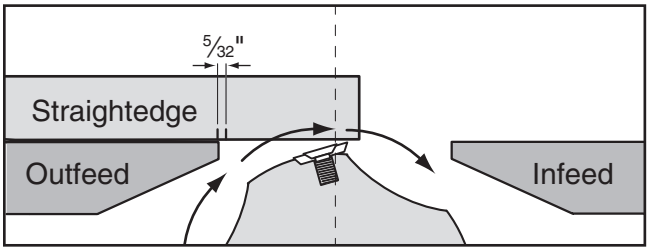


Figure 47. Cutter drags straightedge forward to line up 2nd mark with edge of outfeed table.

9. Tighten the outfeed table lock knob located in the center of the handwheel.

10. Adjust the stop bolt so it just touches the bottom of the outfeed table, then tighten the jam nut up against the casting to prevent the stop bolt from moving.

11. Replace the fence, cutterhead guard, and all covers and guards removed during the procedure. Make sure that the cutterhead guard functions properly when reinstalled.

Checking/Adjusting Table Parallelism

If the tables are not parallel with the cutterhead or each other, then poor cutting results and kickback can occur.

Tools Needed	Qty
Straightedge	1
Wrench 17mm	1
Hex Wrench 8mm	1
Hex Wrench 4mm	1
Hex Wrench 3mm	1

Checking Outfeed Table Parallelism

1. DISCONNECT JOINTER FROM POWER!

2. Remove the cutterhead guard and fence.

3. Loosen the jam nut and stop bolt located under the outfeed table (see **Figure 45**). Make sure to back the stop bolt away from the area where it contacts the table. This will allow the table room to move during the adjustments in the following steps.

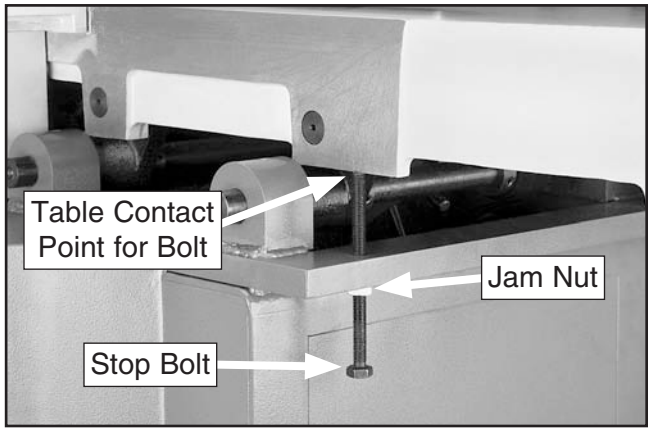


Figure 48. Outfeed table stop bolts.

4. Rotate the cutterhead pulley so you can access the cutterhead body with the straightedge between the inserts, as shown in **Figure 49**.

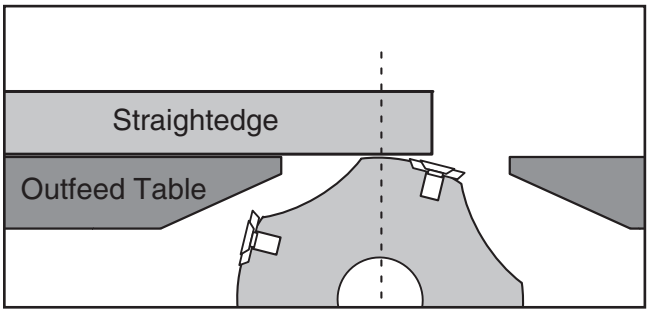


Figure 49. Adjusting outfeed table even with cutterhead body.

5. Place the straightedge on the outfeed table so it hangs over the cutterhead, then lower the outfeed table until the straightedge just touches the cutterhead body (make sure it doesn't touch any inserts).

6. Place the straightedge in the positions shown in **Figure 50**. In each position, the straightedge should touch the cutterhead body (without touching any inserts) and sit flat on the outfeed table.

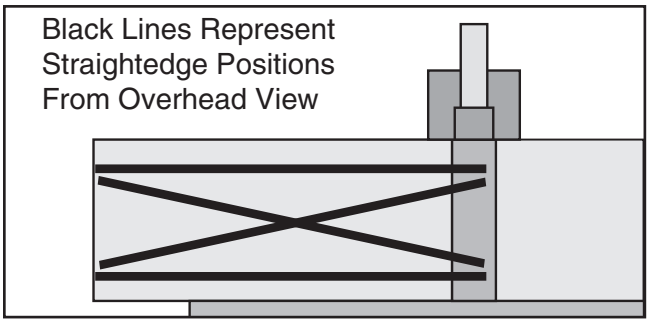


Figure 50. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

—If the straightedge touches the cutterhead body and sits flat across the outfeed table in each position, then the outfeed table is already parallel with the cutterhead. Follow the **Checking Infeed Table** instructions on the next page.

—If the straightedge does not touch the cutterhead or sit flat on the outfeed table in some of the positions, but it does on others, then the outfeed table is not parallel with the cutterhead. Follow the **Adjusting Table Parallelism** instructions on the next page.

Checking Infeed Table

Before checking the infeed table, make sure you have checked the outfeed table parallelism first. If the outfeed table is not parallel to the cutterhead body, correct this issue before continuing with this procedure. The fence and cutterhead guard must also remain removed for this procedure.

Also, the outfeed table height must be properly set or you'll get false readings during this procedure (refer to **Setting Outfeed Table Height** on **Page 33** for detailed instructions).

To check the infeed table:

1. DISCONNECT JOINTER FROM POWER!

2. Rotate the cutterhead so the inserts will not interfere, then place the straightedge halfway across the infeed table and halfway over the outfeed table and adjust the infeed table even with the outfeed table, as shown in **Figure 51**.

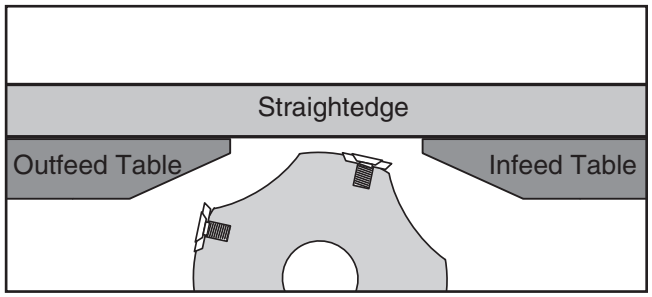


Figure 51. Infeed and outfeed tables set evenly.

3. Place the straightedge in the positions shown in **Figure 52**. In each position, the straightedge should sit flat against both the outfeed table and the infeed table.

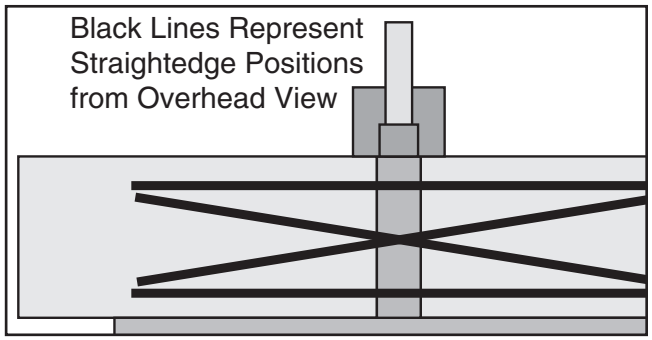


Figure 52. Straightedge positions for checking infeed/outfeed table parallelism.

—If the straightedge sits flat (there are no gaps under the straightedge of more than 0.002") against both the infeed and outfeed table, then the tables are parallel. Replace the cutterhead guard, fence, and rear stand panel.

—If the straightedge does not sit flat against both the infeed and outfeed table in any of the positions, then follow the **Adjusting Table Parallelism** instructions.

Adjusting Table Parallelism

For safe and proper cutting results, the tables must be parallel to the cutterhead. Adjusting them to be parallel is a task of precision and patience, and may take up to one hour or more to complete. Luckily, this is considered a permanent adjustment and should not need to be repeated for the life of the machine.

Due to the complex nature of this task, we recommend that you double check the current table positions to make sure that they really need to be adjusted before starting.

Each table has four pivot points that allow the table position to be adjusted. Some of the pivot points are constructed with eccentric bushings that allow the pivot point to adjust the table position. Each eccentric bushing is locked in place by piggybacked set screws (one on top of the other) and can be adjusted when the set screws are loosened.

The correct order for adjusting the table parallelism is to first adjust the outfeed table parallel with the cutterhead, then adjust the infeed table parallel with the outfeed table.

When setting the outfeed table, all measurements MUST be made from the cutterhead body—not the inserts—or the results may be skewed.

Important: *The steps that follow are intended to be performed directly after the steps involved in "Checking Outfeed Table Parallelism" on **Page 35**. Do not continue until you have performed those steps.*

Adjusting Outfeed Table Parallelism

1. Place the straightedge on the outfeed table so it hangs over the cutterhead, and lower the outfeed table until the straightedge just touches the cutterhead body, as shown in **Figure 53**.

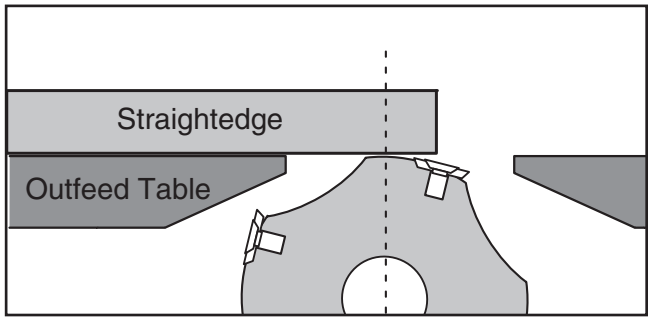


Figure 53. Adjusting outfeed table even with cutterhead body.

2. Remove the cover panels from the front and rear of the machine to expose the eccentric bushings shown, in **Figure 54**.

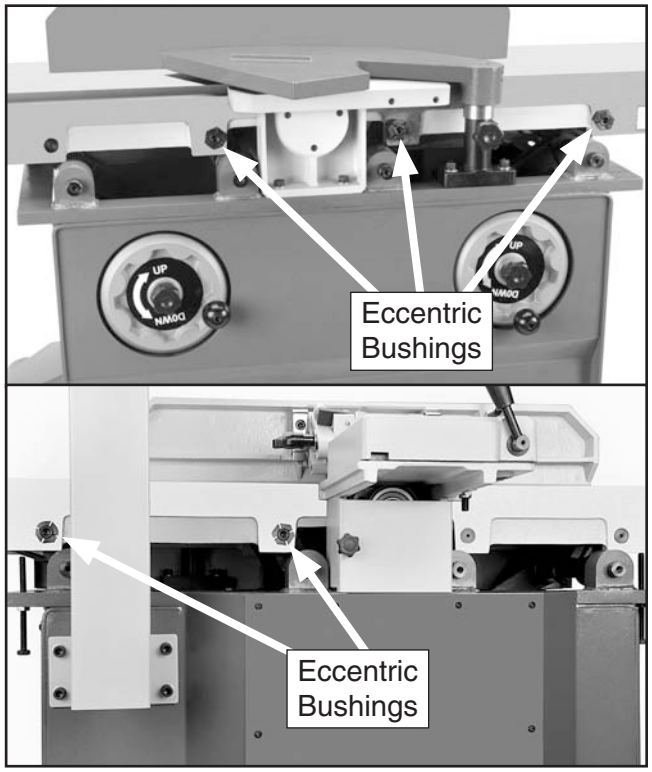


Figure 54. Location of eccentric bushings.

3. Place the straightedge in one of the positions shown in **Figure 52**.

4. Loosen the cap screw in the center of the outfeed table adjustment bolt three full turns, then loosen the set screw that is directly underneath the adjustment bolt (see **Figure 55**).

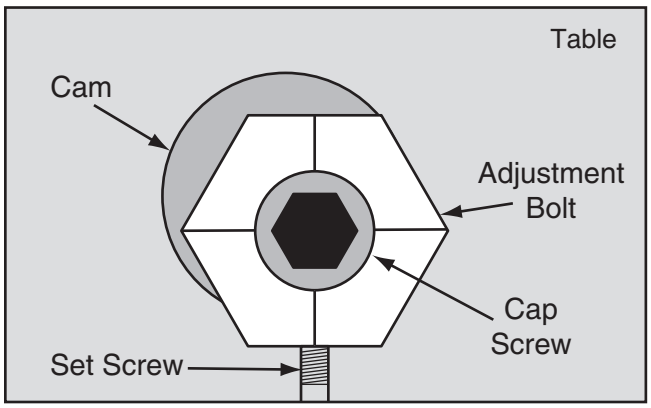


Figure 55. Illustration of the table adjustment bolt components.

Note: *The goal of the next step is to bring the outfeed table parallel to the cutterhead body from front-to-back by raising or lowering the front corner of the outfeed table.*

5. The adjustment bolt shaft is cam-shaped, as shown in **Figure 55**, and connects the table to the lifting arm. Rotate the adjustment bolt in very small increments to raise or lower the front corner of the outfeed table until the surface is the correct height above the cutterhead, as instructed in **Step 4**.

6. Re-check the table height at the back edge of the table, as instructed in **Step 4**.

   —If the table height is correct from front-to-back, no further adjustments are necessary. Go to **Step 7** to finish this procedure.

   —If the table height from front-to-back is not correct and the same, loosen the table lock and use the handwheel to bring the back of the table to the correct height above the cutterhead body, then repeat **Step 5**. Continue this process until the table height is correct and the same from front-to-back.

7. When the outfeed table height is correct and parallel to the cutterhead, re-tighten the adjustment bolt cap screw and set screw (see **Figure 55**), then tighten the table lock.

8. Loosen the jam nut and adjust the outfeed stop bolt underneath the table so that it just touches the bottom of the tables, as shown in **Figure 45** on **Page 34**, then re-tighten the jam nut.

   Note: *When adjusted to the correct outfeed table height, use the stop bolt for a convenient method of ensuring the outfeed table is set at the proper height.*

9. When the **Adjusting Outfeed Table Parallelism** procedure is successfully completed, proceed to **Adjusting Infeed Table Parallelism**.

Adjusting Infeed Table Parallelism

1. Make sure that all steps in the **Adjusting Outfeed Table Parallelism** procedure have been successfully completed and that the jointer is still disconnected from power.

2. Make sure the table surfaces and the precision straightedge are free from any debris that would interfere with taking measurements, then place the straightedge equally over the back of the outfeed and infeed tables.

   Note: *Make sure the straightedge is not in contact with an insert.*

3. With the use of a magnet or an assistant, make sure that the straightedge stays flat against the full length of its contact with the outfeed table during the following steps.

4. Use the handwheel to adjust the infeed table as close as possible to the straightedge, then look closely for any gaps between the infeed table and the straightedge. Repeat this process on the front of the infeed table.

   —If there are no gaps as the straightedge is positioned on both the back and front of the tables, then the infeed table is parallel with the outfeed table and the cutterhead—thus, no further adjustments are required. Proceed to **Step 7**.

   —If there are gaps between the straightedge and the infeed table, make a note of how much and where the gaps are, then proceed to **Step 5**.

   Note: *To access the table adjustment bolts on the back side of the infeed table, remove the back table cover.*

5. Use the same process you performed in **Step 5** on **Page 37** to raise or lower the left or right end of the infeed table to eliminate the gaps. Adjust the adjustment bolts equally on each side for the targeted end of the table, one after the other, in very small increments (see **Figure 56**).

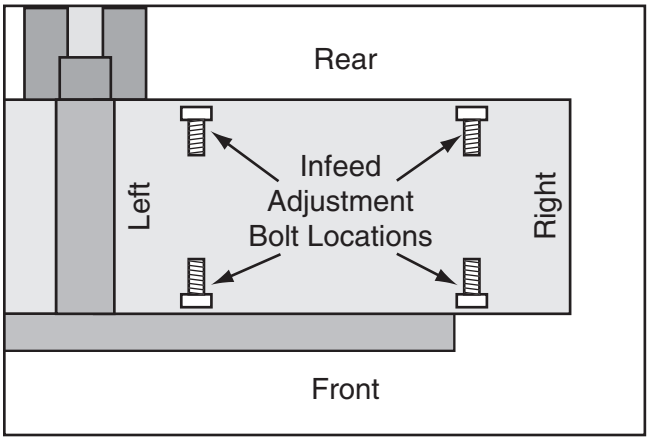


Figure 56. Locations of the infeed table adjustment bolts.

6. Repeat **Steps 4–5** until the infeed table is completely parallel to the outfeed table, which will also make it parallel to the cutterhead.

7. If the table adjustment cap and set screws are loose, re-tighten them and re-install the previously removed parts.

8. Recalibrate the depth scale to ensure that it remains accurate after moving the infeed table (see **Page 40**).

Setting Infeed Table Stop Bolt

The infeed table on your jointer has a stop bolt (see **Figure 57**) that should be set to prevent the table from adjusting lower than ⅛" below the where the infeed table is even with the outfeed table. This is considered the "safe" maximum depth of cut for any single pass. Cutting deeper than this on a single pass increases the risk of kickback beyond a tolerable level.

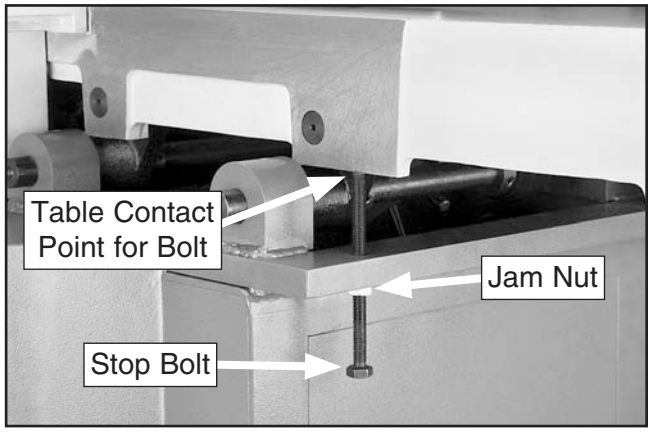


Figure 57. Infeed table stop bolt.

The jam nuts on the stop bolts allow them to be locked in place once they're set, so they do not inadvertently move or "creep" out of adjustment.

Before adjusting the infeed table stop bolt, make sure the depth scale is properly calibrated, as described on **Page 40**.

To adjust the infeed table stop bolts:

1. Loosen the infeed table lock knob located in the center of the handwheel.

2. Loosen the jam nut and stop bolt located under the table (see **Figure 57**). Make sure to back the stop bolt away from the area where it contacts the table. This will allow the table room to move during the adjustments in the following steps.

3. Move the infeed table to where the depth scale reads ⅛".

4. Adjust the stop bolt so it touches table contact point on the bottom of the infeed table, then tighten the jam nut up against the casting to prevent the stop bolt from moving.

   Congratulations! The infeed table stop bolt is now properly set.

Calibrating Depth Scale

The depth scale on the infeed table can be calibrated or "zeroed" if it is not correct.

Tools Needed	Qty
Straightedge	1
Phillips Screwdriver	1
Wrench 17mm	1
Hex Wrench 5mm	1

To calibrate the depth scale:

1. DISCONNECT JOINTER FROM POWER!

2. Use the straightedge as a guide to adjust the infeed table exactly even with the outfeed table, as shown in **Figure 58**.

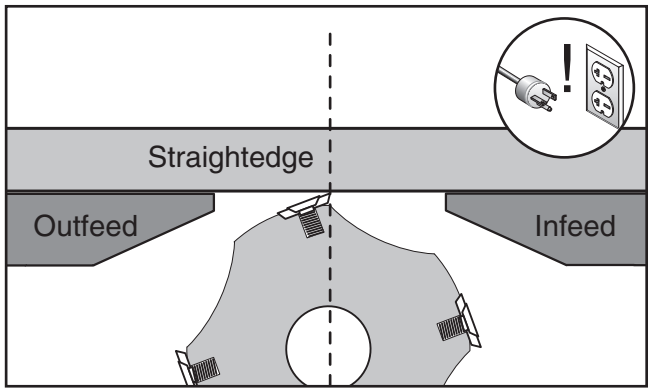


Figure 58. Infeed table even with outfeed table.

3. Using a screwdriver, adjust the scale pointer adjustment screw to position the pointer at the "0" mark (**Figure 59**).

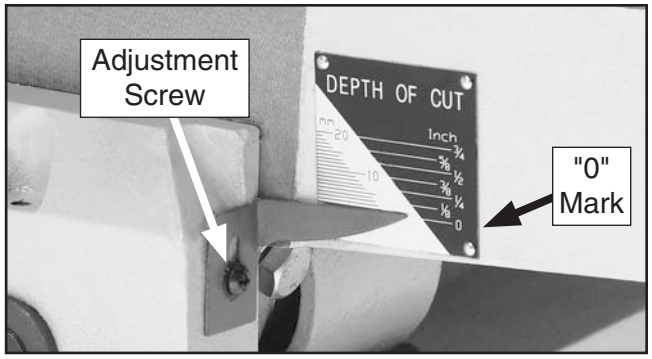


Figure 59. Depth scale adjusted to “0” position.

Setting Fence Stops

The fence stops simplify the task of adjusting the fence 45˚ inward, 90˚, and 45˚ outward (135˚).

Tools Needed	Qty
45° Square	1
90° Square	1
Sliding Bevel	1
Wrench 14mm	1

To set the 45˚ inward fence stop:

1. Tilt the fence approximately 45° inward (**Figure 60**), using a 45° square as a guide.

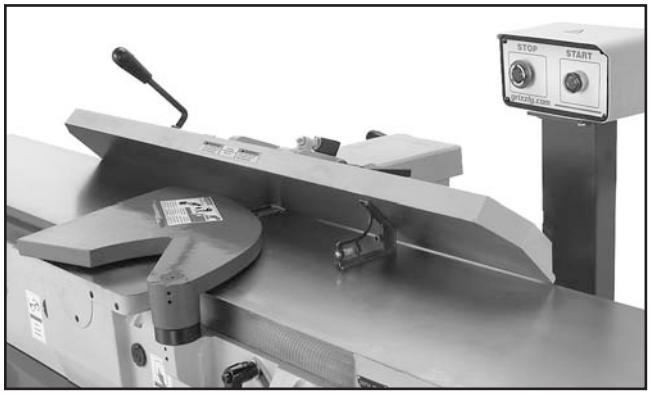


Figure 60. Fence adjusted 45˚ inward.

2. Loosen the jam nut on the 45° inward stop bolt shown in **Figure 61**.

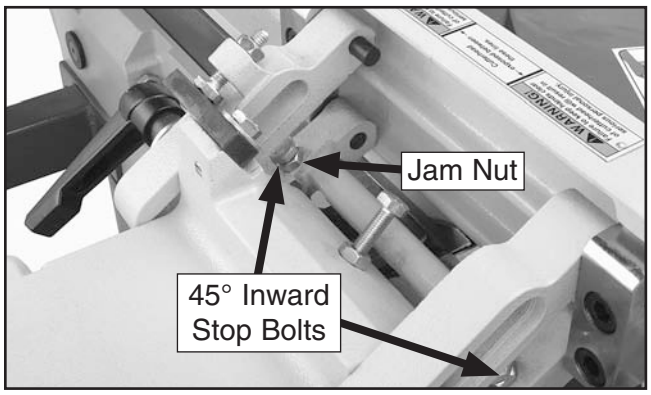


Figure 61. 45° inward stop bolt (one of two shown).

3. Adjust the stop bolts until the fence is exactly 45° inward while resting on the bolts (verify the angle with a 45° square).

4. Retighten the jam nut loosened in **Step 2**.

To set the 90˚ fence stop:

1. Lower the stop block against the fence, as shown in **Figure 62**, and loosen the fence tilt lock.

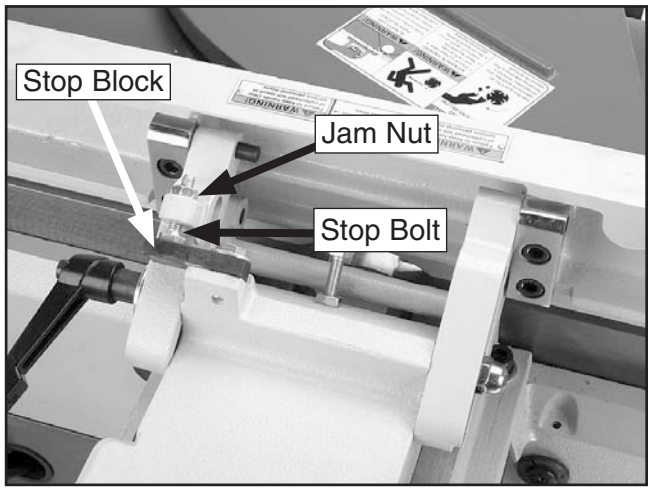


Figure 62. Adjusting fence to 90˚.

2. Tilt the fence to the 90° position.

3. Using a 90° square, check the fence angle.

   —If it is not set at exactly 90°, loosen the jam nut and adjust the stop bolt until the fence is exactly 90° as shown in **Figure 62**.

4. Tighten the jam nut.

To set the 45° outward fence stop:

1. Raise the stop block, loosen the fence tilt lock, and position the fence against the 45° outward stop bolt.

   —If the fence is not set at exactly 45˚ outward, loosen the jam nut on the 45˚ outward fence stop bolt (**Figure 63**).

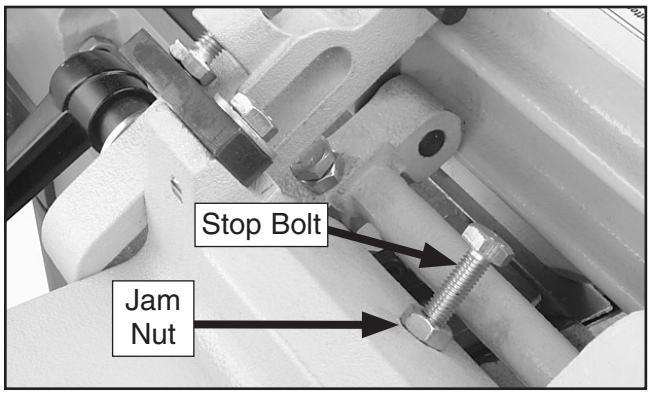


Figure 63. Adjusting fence 45˚ outward.

2. Adjust the 45˚ outward stop bolt until the fence is exactly 45° outward while resting on the bolt (check the angle with a sliding bevel set to 135°).

3. Retighten the jam nut loosened in **Step 2**.

Drive Belt

The drive belt must be properly aligned and tensioned in order to transfer power from the motor to the cutterhead at optimal efficiency.

After the first 8–16 hours of operation, a new belt will stretch slightly, decreasing the efficiency of power transfer. To ensure optimal power transmission, check and adjust the belt tension if necessary.

Checking Belt Tension

Tools needed: **Qty**
Hex Wrench 8mm..... 1

To check the belt tension:

1. DISCONNECT JOINTER FROM POWER!

2. Remove the rear access door and open the rear cutterhead door at the back of the machine (see **Figure 64**).

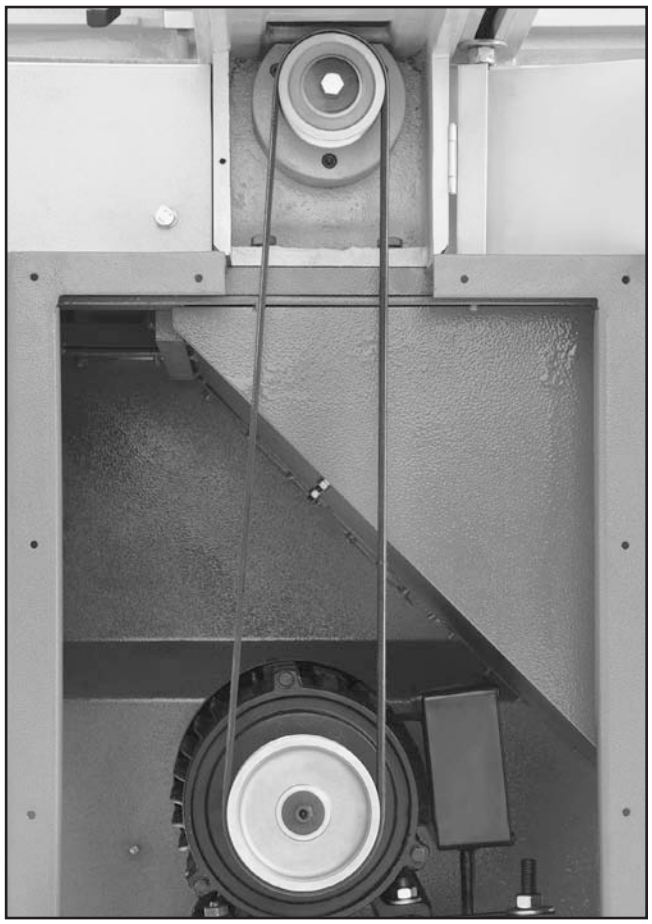


Figure 64. Belt and pulleys.

3. Using your index finger or thumb, push the center of the belt (between the pulleys) with moderate force, and note the amount of deflection observed (see **Figure 65**).

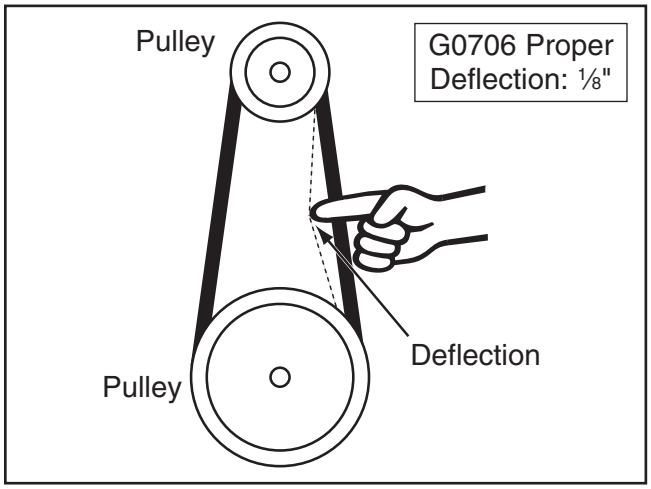


Figure 65. Checking belt deflection.

Note: *When properly tensioned, the belt on the Model G0706 should not have more than 1/8" deflection.*

4. Inspect the pulley alignment to verify that pulleys are properly aligned (see **Page 43**).

5. If the deflection exceeds the proper amount, increase the belt tension as necessary; otherwise, if the belt deflection is acceptable, replace the rear access door and close the rear cutterhead door.

Adjusting Belt Tension

The belt is tension is controlled by moving the motor mount up or down. The motor mount lug is sandwiched between two large hex nuts, which control the movement of the motor mount by either being rotated up or down the threaded stud.

Tools needed: **Qty**
Wrench 17mm..... 1
Hex Wrench 8mm..... 1

To adjust the belt tension:

1. DISCONNECT JOINTER FROM POWER!

2. Remove the rear access door and open the rear cutterhead door at the back of the machine (see **Figure 64**).

3. Rotate both hex nuts in the order that you want to move the motor mount, following the sequential order shown in **Figure 66**. (Essentially you move one hex nut out of the way, then use the other to push the motor mount.)

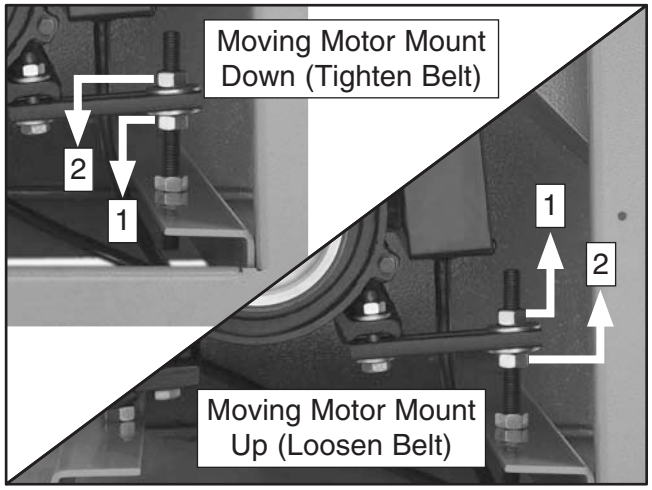


Figure 66. Direction of motor mount and hex nut movement to adjust belt tension.

4. Adjust the belt tension until the proper deflection is attained. See **Checking Belt Tension** on the previous page.

5. When the belt tension is correct, tighten both hex nuts against the motor mount (without moving it) to lock it in place.

6. Replace the rear access door and close the rear cutterhead door.

Replacing Belt

1. Follow **Steps 1–3** in the instructions for **Adjusting Belt Tension** (see previous page) and loosen the belt enough so that you can roll it off the pulleys.

2. Roll the new belt on the pulleys, making sure all V's in the belt are meshed in the proper pulley grooves.

3. Finish the instructions for **Adjusting Belt Tension** by following **Steps 4–6**.

Pulley Alignment

A major factor in proper power transmission and belt life is pulley alignment. If pulleys are not aligned, the belt runs hotter, wears faster, and transmits power less efficiently. The pulleys are aligned at the factory, and under normal circumstances, will not need to be adjusted through the life of the machine. However, if the pulleys ever become loose or are removed, or if the motor is ever removed from the motor mount, then the pulleys must be realigned.

You can check to see if your pulleys are aligned by following the steps for **Checking Belt Tension** on **Page 42**, then placing a straightedge across the front of both pulleys. When properly aligned, both pulleys will evenly touch the straightedge, as illustrated in **Figure 67**.

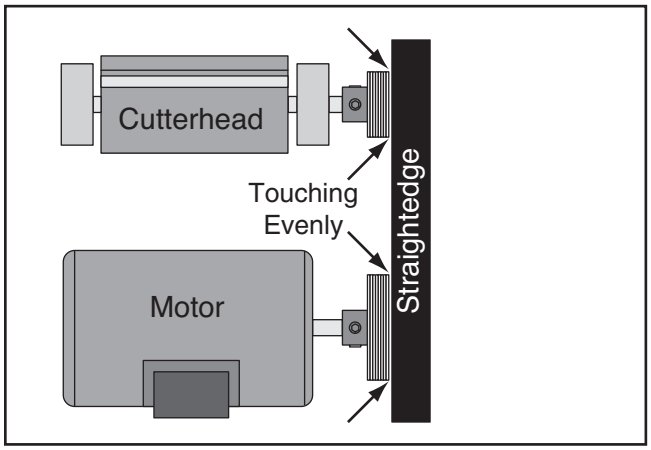


Figure 67. Checking pulley alignment.

If the pulleys are not aligned, then the motor can be adjusted horizontally by loosening the three motor mount bolts (see **Figure 68**), sliding the motor in the necessary direction, then tightening the motor mount bolts. (It may be necessary to loosen belt tension to slide motor—refer to **Adjusting Belt Tension** on **Page 42**.)

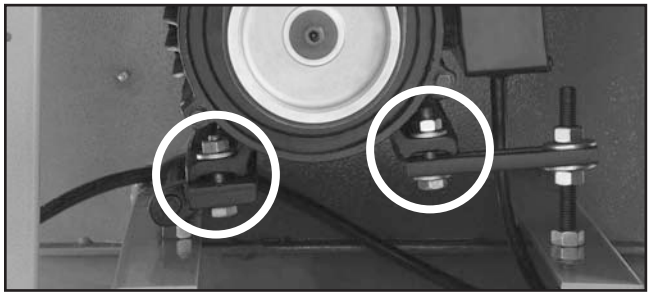


Figure 68. Motor mount bolts (2 of 3 shown).

SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

⚠WARNING
Wiring Safety Instructions

1. **SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

2. **MODIFICATIONS.** Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved aftermarket parts.

3. **WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

4. **CIRCUIT REQUIREMENTS.** You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

5. **WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

6. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

7. **CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

8. **EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

G0706 Electrical Components

Figure 69. Motor junction box.

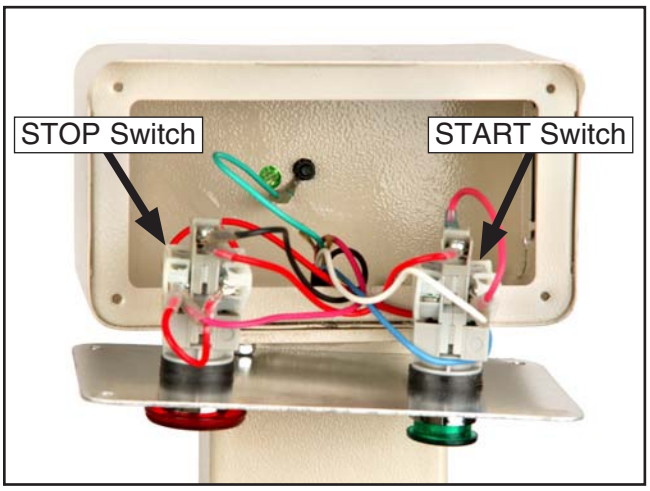


Figure 70. Control panel.

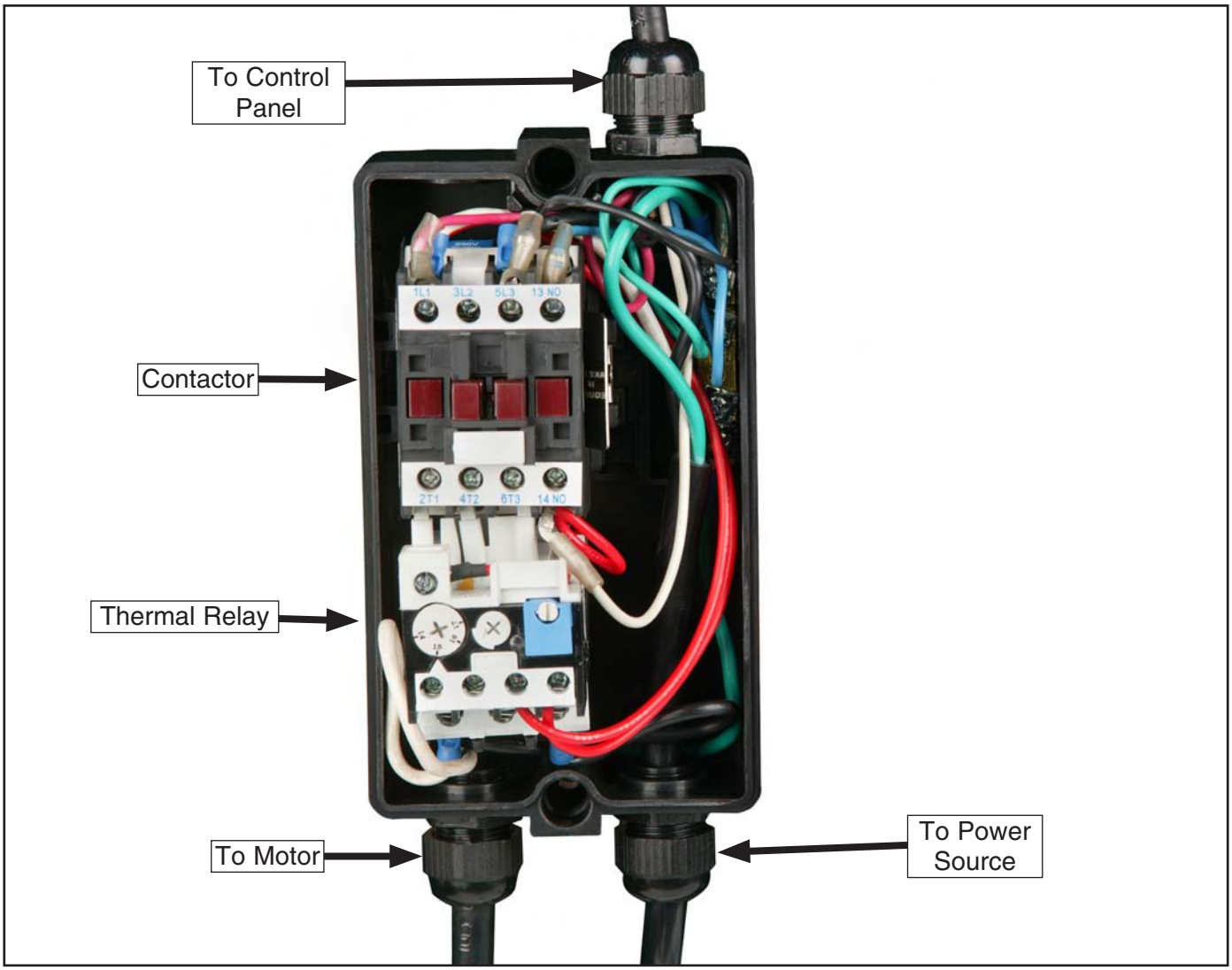
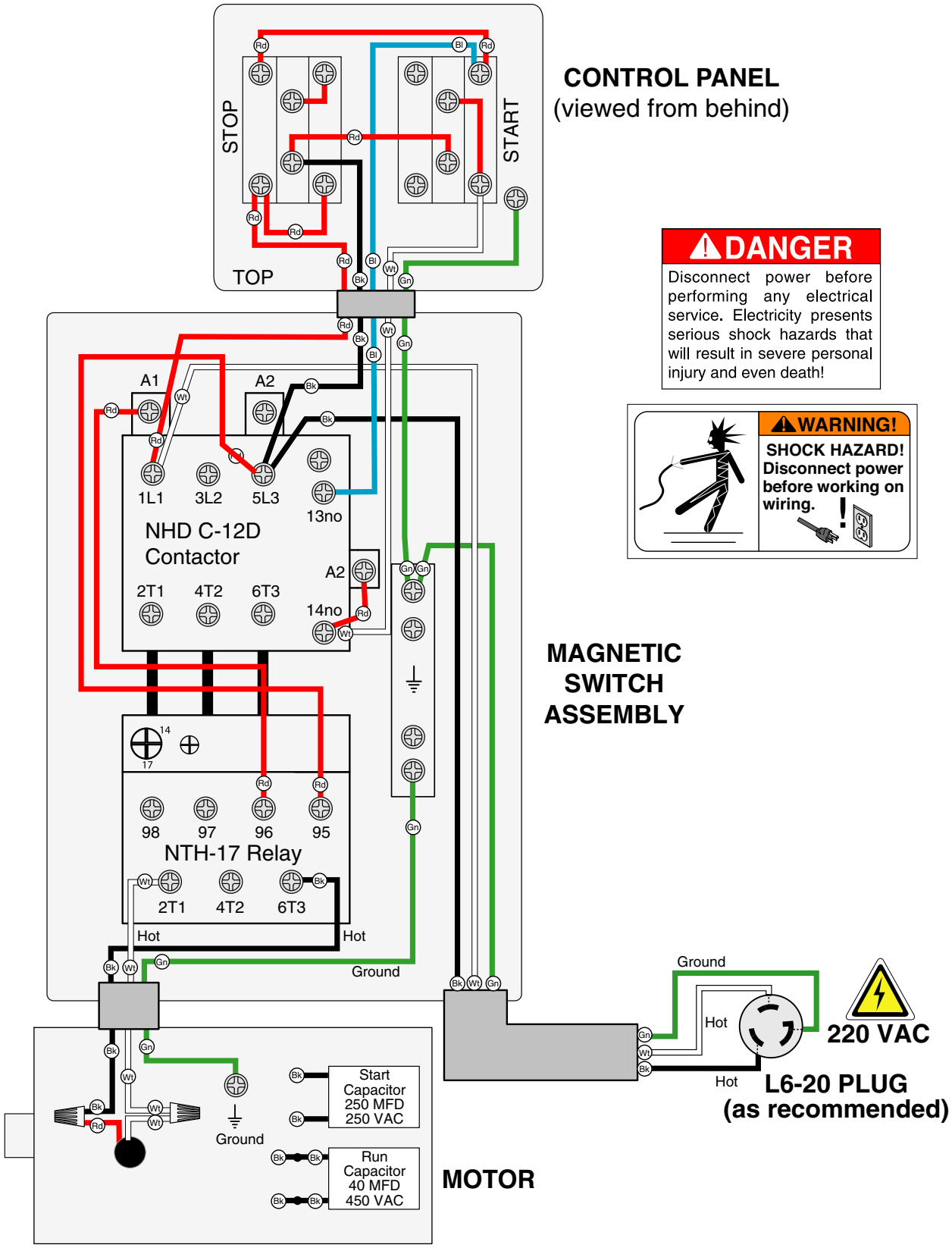


Figure 71. Magnetic switch assembly (behind right access panel).

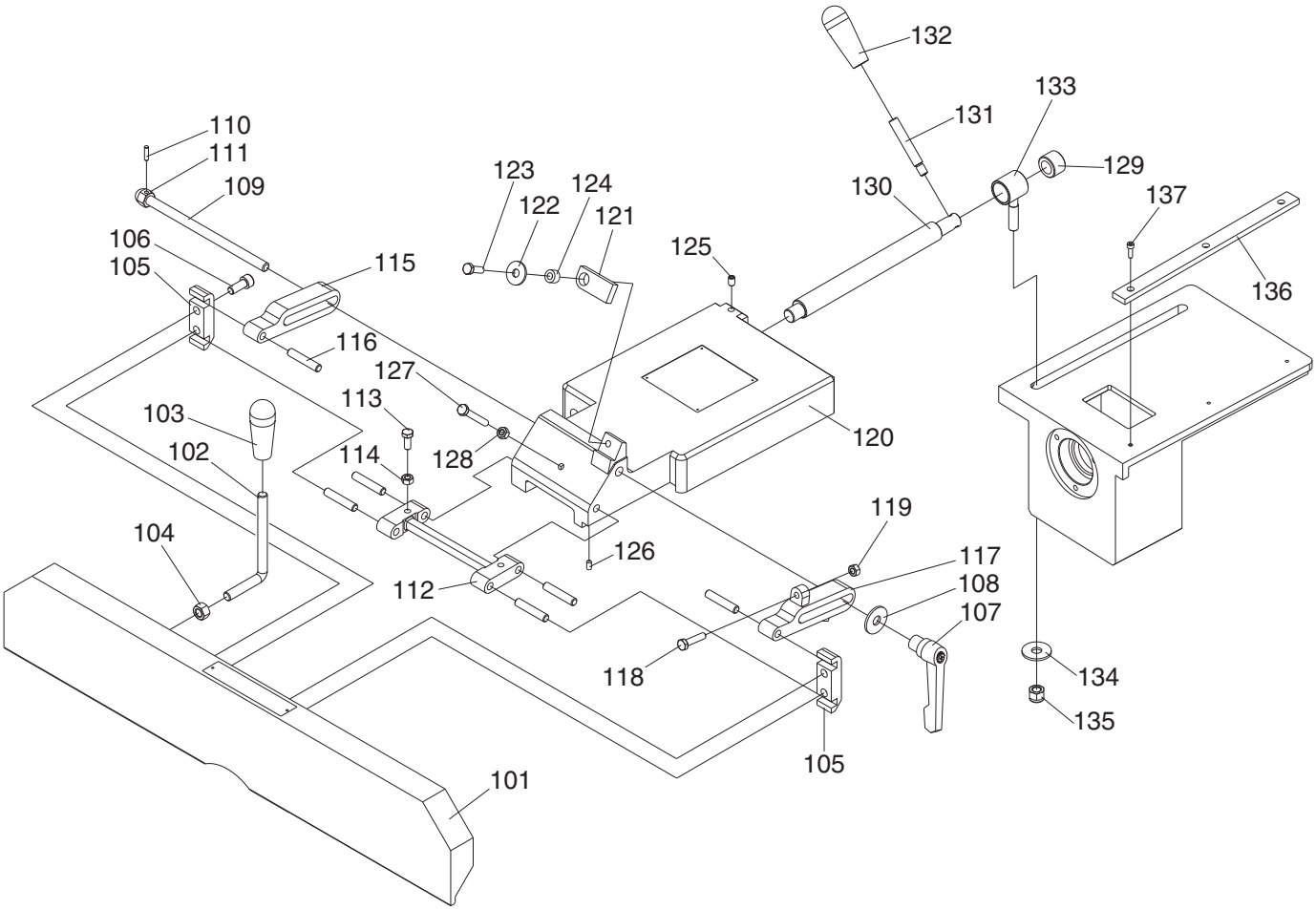
G0706 Wiring Diagram



READ ELECTRICAL SAFETY ON PAGE 44!

SECTION 9: PARTS

Fence



REF	PART #	DESCRIPTION
101	P0706101	FENCE
102	P0706102	HANDLE ROD
103	P0706103	HANDLE M12-1.75
104	PN09M	HEX NUT M12-1.75
105	P0706105	CLAMP
106	PCAP64M	CAP SCREW M10-1.5 X 25
107	P0706107	LOCK LEVER ASSY
108	PW06M	FLAT WASHER 12MM
109	P0706109	DOUBLE END THREADED ROD
110	PRP03M	ROLL PIN 5 X 20
111	P0706111	PINNED ACORN NUT M12-1.75
112	P0706112	SUPPORT BRACKET
113	PB09M	HEX BOLT M8-1.25 X 20
114	PN03M	HEX NUT M8-1.25
115	P0706115	LEFT BRACKET
116	P0706116	PIN
117	P0706117	RIGHT BRACKET
118	PB20M	HEX BOLT M8-1.25 X 35
119	PN03M	HEX NUT M8-1.25

REF	PART #	DESCRIPTION
120	P0706120	SLIDING BRACKET
121	P0706121	BLOCK
122	PW01M	FLAT WASHER 8MM
123	PB07M	HEX BOLT M8-1.25 X 25
124	P0706124	COLLAR
125	PSS14M	SET SCREW M8-1.25 X 12
126	PSS04M	SET SCREW M6-1 X 12
127	PB30M	HEX BOLT M8-1.25 X 55
128	PN03M	HEX NUT M8-1.25
129	P0706129	COLLAR
130	P0706130	ECCENTRIC SHAFT
131	P0706131	HANDLE ROD
132	P0706103	HANDLE M12-1.75
133	P0706133	SLIDING BUSHING ASSY
134	PW06M	FLAT WASHER 12MM
135	PLN09M	LOCK NUT M12-1.75
136	P0706136	SLIDING RAIL
137	PCAP20M	CAP SCREW M5-.8 X 14

Table

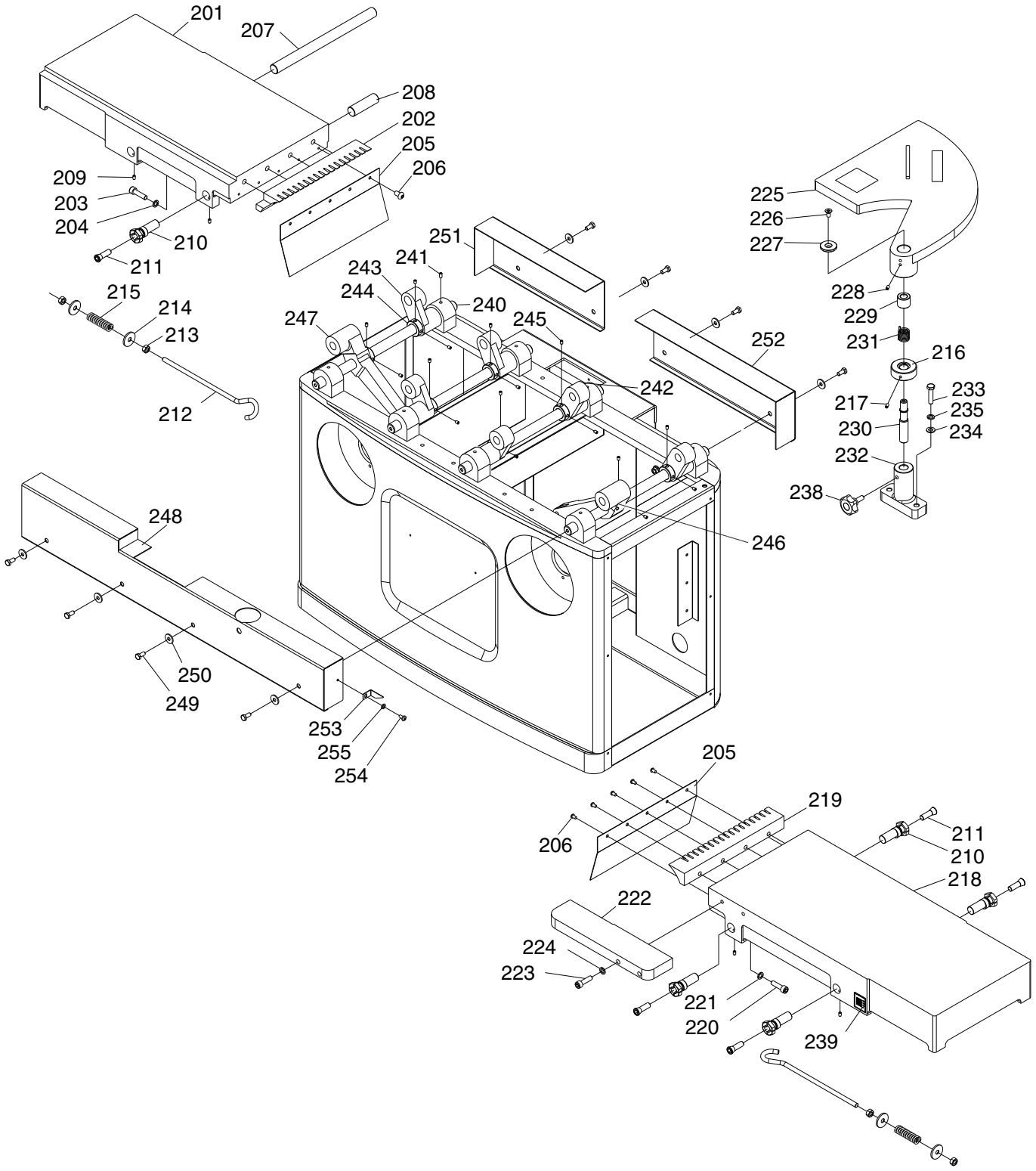

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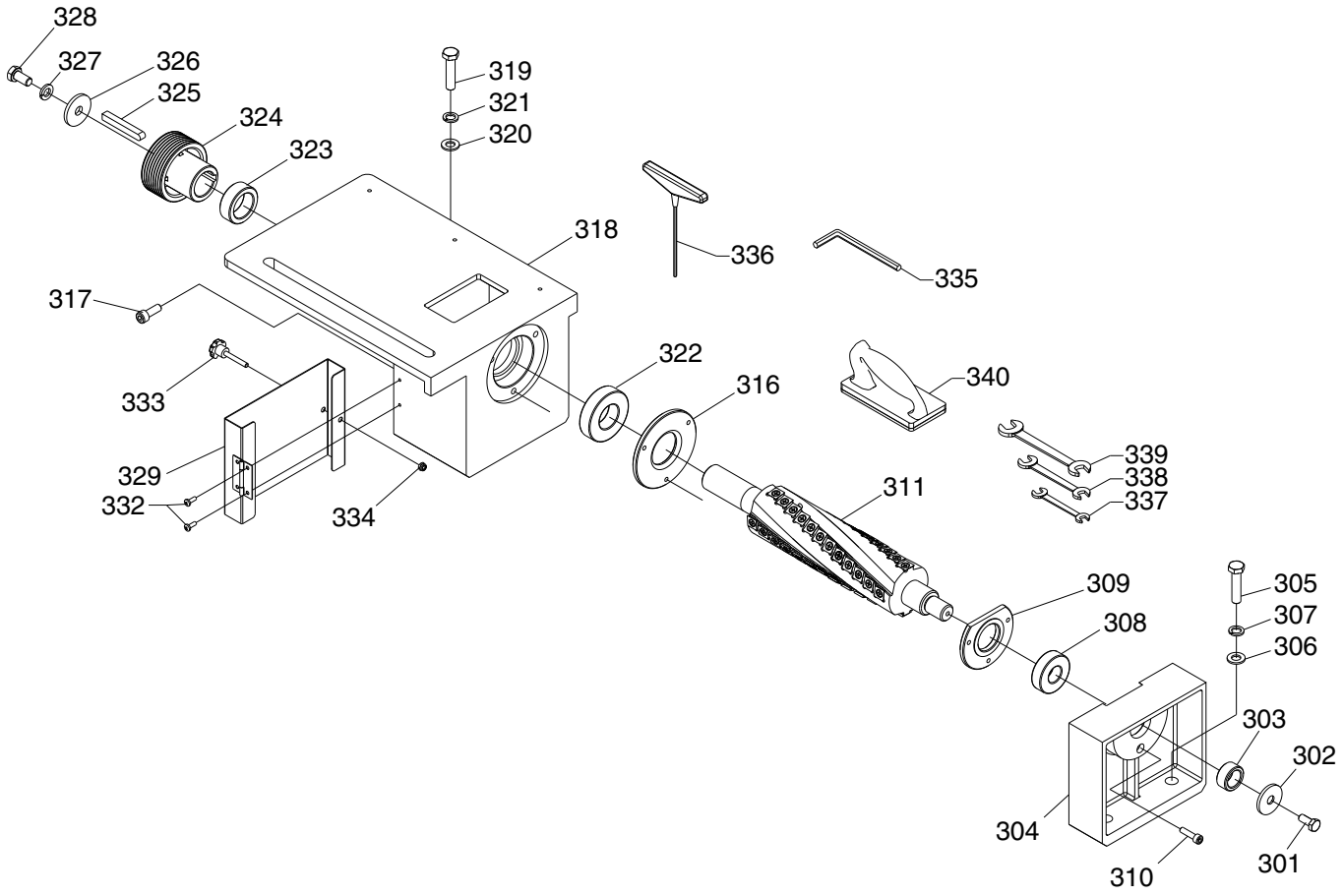
Table Parts List

REF	PART #	DESCRIPTION
201	P0706201	OUTFEED TABLE
202	P0706202	OUTFEED TABLE LIP
203	PCAP84M	CAP SCREW M10-1.5 X 35
204	PLW06M	LOCK WASHER 10MM
205	P0706205	DUST BOARD
206	PFH43M	FLAT HD SCR M6-1 X 10
207	P0706207	TABLE SPINDLE
208	P0706208	ROD (SHORT)
209	PSS14M	SET SCREW M8-1.25 X 12
210	P0706210	BED PIVOT PIN
211	PCAP77M	CAP SCREW M12-1.75 X 30
212	P0706212	J-ROD
213	PN02M	HEX NUT M10-1.5
214	PW04M	FLAT WASHER 10MM
215	P0706215	TENSION SPRING
216	P0706216	SHAFT COLLAR
217	PSS04M	SET SCREW M6-1 X 12
218	P0706218	INFEED TABLE
219	P0706219	INFEED TABLE LIP
220	PCAP84M	CAP SCREW M10-1.5 X 35
221	PLW06M	LOCK WASHER 10MM
222	P0706222	RABBETING ARM
223	PCAP72M	CAP SCREW M10-1.5 X 30
224	PLW06M	LOCK WASHER 10MM
225	P0706225	CUTTERHEAD GUARD
226	PFH23M	FLAT HD SCR M8-1.25 X 16
227	P0706227	GUARD WASHER

REF	PART #	DESCRIPTION
228	PSS04M	SET SCREW M6-1 X 12
229	P0706229	ADAPTER
230	P0706230	SHAFT
231	P0706231	TORSION SPRING
232	P0706232	SHAFT HOUSING
233	PCAP84M	CAP SCREW M10-1.5 X 35
234	PW04M	FLAT WASHER 10MM
235	PLW06M	LOCK WASHER 10MM
238	P0706238	KNOB
239	P0706239	DEPTH SCALE
240	P0706240	TABLE HEIGHT SPINDLE
241	PSS14M	SET SCREW M8-1.25 X 12
242	P0706242	SMALL TABLE SUPPORT
243	P0706243	BIG TABLE SUPPORT
244	P0706244	LOCK COLLAR
245	PSS20M	SET SCREW M8-1.25 X 8
246	P0706246	INFEED TABLE LIFTING ARM
247	P0706247	OUTFEED TABLE LIFTING ARM
248	P0706248	FRONT TABLE COVER
249	PB06M	HEX BOLT M8-1.25 X 12
250	PW01M	FLAT WASHER 8MM
251	P0706251	OUTFEED TABLE REAR COVER
252	P0706252	INFEED TABLE REAR COVER
253	P0706253	POINTER
254	PS14M	PHLP HD SCR M6-1 X 12
255	PW03M	FLAT WASHER 6MM

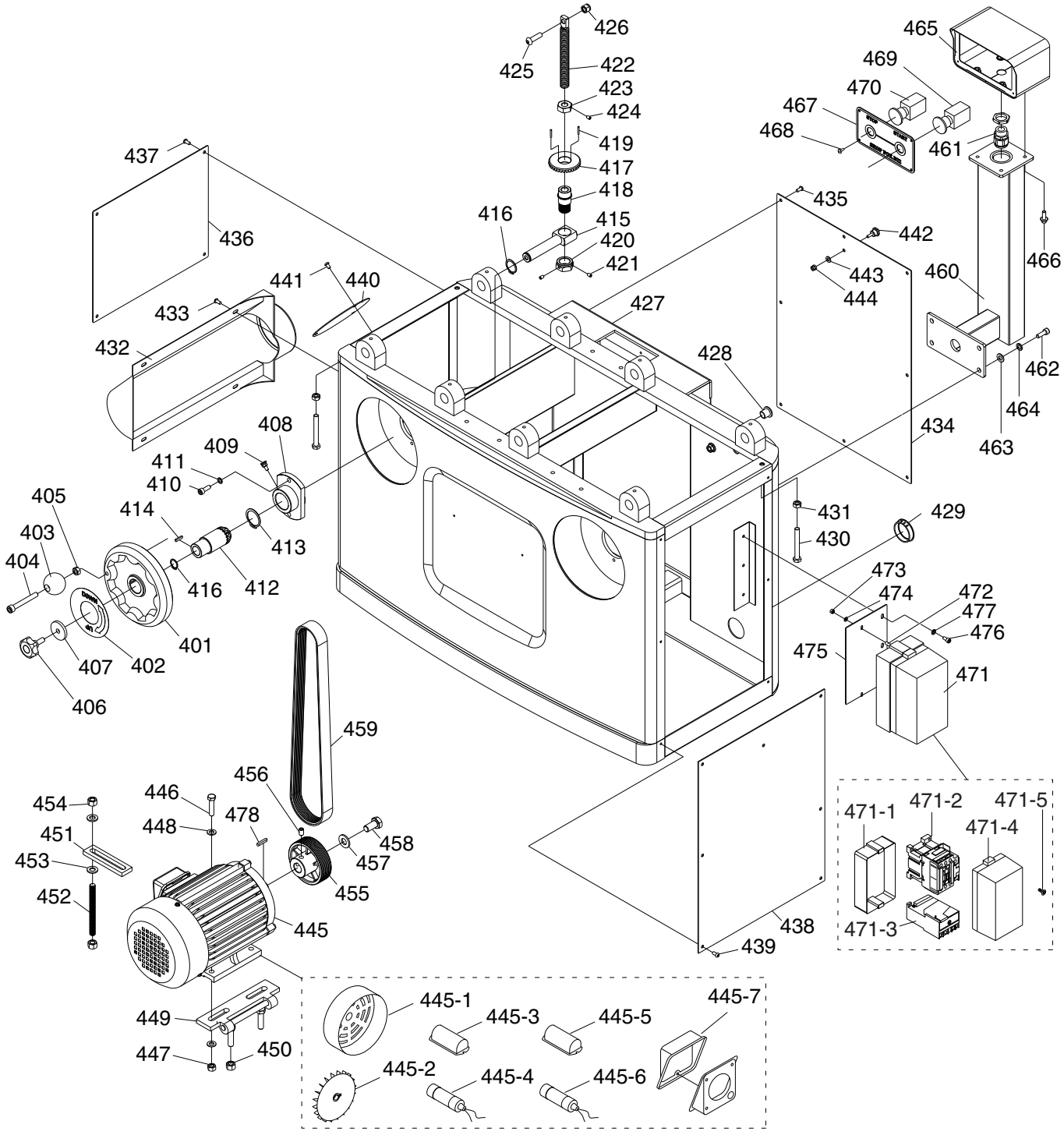
Cutterhead



REF	PART #	DESCRIPTION
301	P0706301	FRONT CUTTERHEAD SCREW
302	PW01M	FLAT WASHER 8MM
303	P0706303	FRONT CUTTERHEAD BUSHING
304	P0706304	FRONT BEARING SUPPORT
305	PB14M	HEX BOLT M10-1.5 X 35
306	PW04M	FLAT WASHER 10MM
307	PLW06M	LOCK WASHER 10MM
308	P6204Z	BALL BEARING 6204Z
309	P0706309	FRONT BEARING COVER
310	PCAP06M	CAP SCREW M6-1 X 25
311	P0706311	CUTTERHEAD
316	P0706316	REAR BEARING COVER
317	PCAP06M	CAP SCREW M6-1 X 25
318	P0706318	REAR BEARING SUPPORT
319	PB14M	HEX BOLT M10-1.5 X 35
320	PW04M	FLAT WASHER 10MM
321	PLW06M	LOCK WASHER 10MM

REF	PART #	DESCRIPTION
322	P6206Z	BALL BEARING 6206Z
323	P0706323	REAR CUTTERHEAD BUSHING
324	P0706324	CUTTERHEAD PULLEY
325	P0706325	KEY C8 X 60
326	PW04M	FLAT WASHER 10MM
327	PLW06M	LOCK WASHER 10MM
328	P0706328	REAR CUTTERHEAD SHAFT SCREW
329	P0706329	REAR CUTTERHEAD DOOR
332	PHTEK15M	TAP SCREW M4-.7 X 10
333	P0706333	KNOB BOLT M5-.8 X 60
334	PLN02M	LOCK NUT M5-.8
335	PAW08M	HEX WRENCH 8MM
336	P0706336	T-HANDLE HEX WRENCH 4MM
337	PWR810	WRENCH 8/10MM
338	PWR1214	WRENCH 12/14MM
339	PWR1719	WRENCH 17/19MM
340	P0609352	PUSH BLOCK

Stand Assembly

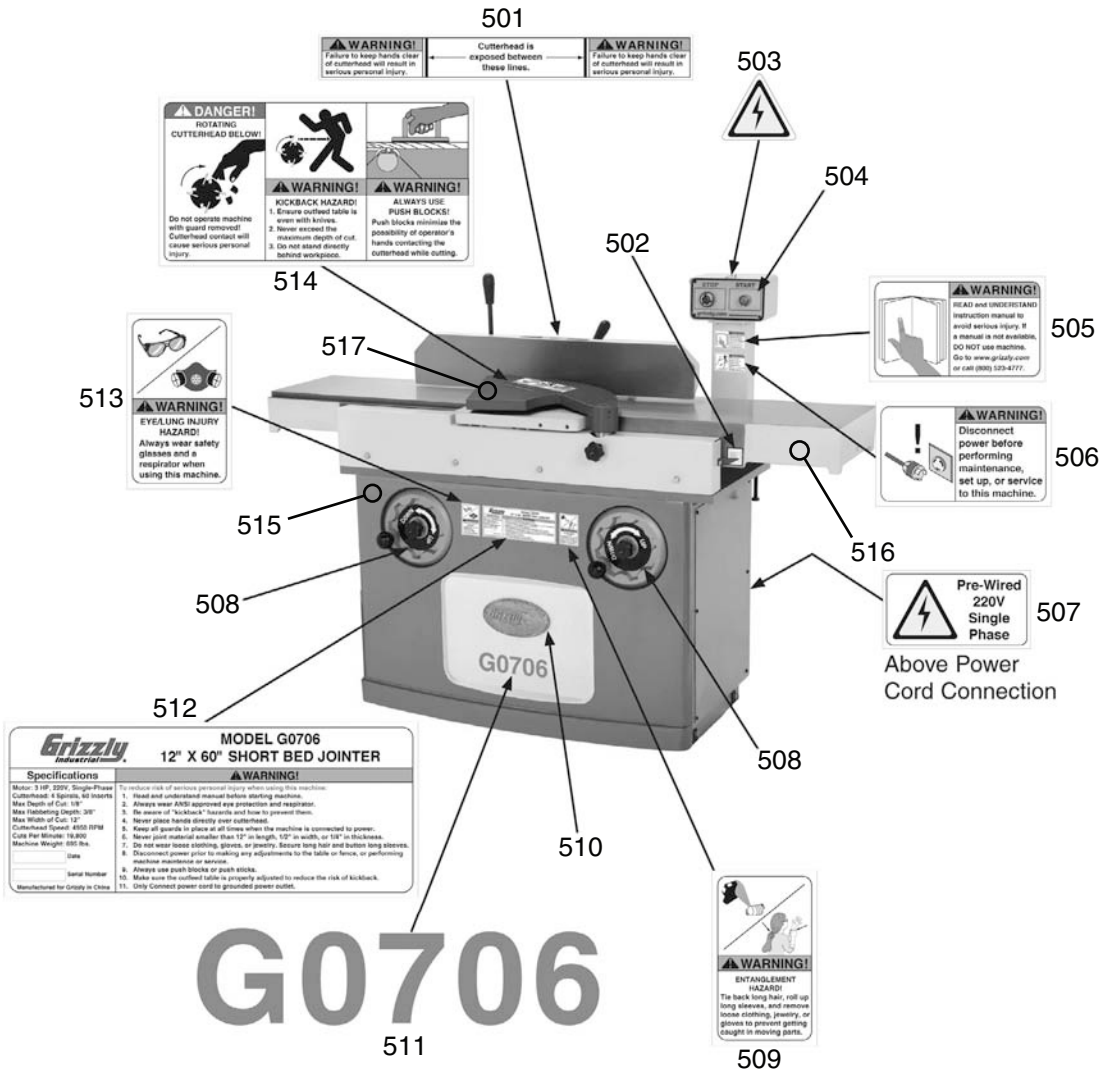


Stand Parts List

REF	PART #	DESCRIPTION
401	P0706401	HANDWHEEL
402	P0706402	HANDWHEEL DIRECTION LABEL
403	P0706403	HANDWHEEL KNOB
404	PCAP71M	CAP SCREW M10-1.5 X 60
405	PN02M	HEX NUT M10-1.5
406	P0706406	KNOB BOLT
407	P0706407	HANDWHEEL WASHER
408	P0706408	LIFTING FIXING SEAT
409	P0706409	OILER-M6
410	PCAP31M	CAP SCREW M8-1.25 X 25
411	PLW04M	LOCK WASHER 8MM
412	P0706412	GEARED COLLAR
413	PR68M	EXT RETAINING RING 40MM
414	PK20M	KEY 5 X 5 X 15
415	P0706415	LIFTING ROD
416	PR10M	EXT RETAINING RING 22MM
417	P0706417	BEVEL GEAR
418	P0706418	LIFTING COLLAR
419	PRP15M	ROLL PIN 3 X 8
420	P0706420	HEX COLLAR
421	PSS02M	SET SCREW M6-1 X 6
422	P0706422	LIFTING GEAR ROD
423	P0706423	LIFTING GEAR ROD HEX COLLAR
424	PSS02M	SET SCREW M6-1 X 6
425	P0706425	FLAT HD SCR M10-1.5 X 45
426	PLN05M	LOCK NUT M10-1.5
427	P0706427	CABINET
428	P0706428	WIRE CLIP
429	P0706429	BIG STRAIN RELIEF
430	P0706430	HEX BOLT M10-1.5 X 130
431	PN02M	HEX NUT M10-1.5
432	P0706432	DUST PORT
433	PFH02M	FLAT HD SCR M6-1 X 12
434	P0706434	REAR ACCESS DOOR
435	PFH02M	FLAT HD SCR M6-1 X 12
436	P0706436	OUTFEED ACCESS DOOR
437	PFH02M	FLAT HD SCR M6-1 X 12
438	P0706438	INFEED ACCESS DOOR
439	PFH02M	FLAT HD SCR M6-1 X 12
440	P0706440	DUST PORT COVER
441	PFH02M	FLAT HD SCR M6-1 X 12
442	P0706442	BACK COVER BOLT
443	PW03M	FLAT WASHER 6MM
444	PLN03M	LOCK NUT M6-1
445	P0706445	MOTOR 3HP 220V 1-PH

REF	PART #	DESCRIPTION
445-1	P0706445-1	MOTOR FAN COVER
445-2	P0706445-2	MOTOR FAN
445-3	P0706445-3	CAPACITOR COVER
445-4	P0706445-4	S CAPACITOR 250M 250V 3.5"L X 1.75"D
445-5	P0706445-5	CAPACITOR COVER
445-6	P0706445-6	R CAPACITOR 40M 450V 3.5"L X 1.5"D
445-7	P0706445-7	JUNCTION BOX
446	PB116M	HEX BOLT M10-1.5 X 45
447	PN02M	HEX NUT M10-1.5
448	PW04M	FLAT WASHER 10MM
449	P0706449	MOTOR BRACKET
450	PN09M	HEX NUT M12-1.75
451	P0706451	TENSION PLATE
452	P0706452	TENSION ROD
453	PW06M	FLAT WASHER 12MM
454	PN09M	HEX NUT M12-1.75
455	P0706455	MOTOR PULLEY
456	PSS75M	SET SCREW M10-1.5 X 16
457	P0706457	MOTOR PULLEY WASHER
458	PB07M	HEX BOLT M8-1.25 X 25
459	P0706459	V-RIBBED BELT 8PK1290
460	P0706460	SWITCH BRACKET
461	P0706461	BALL STRAIN RELIEF
462	PCAP64M	CAP SCREW M10-1.5 X 25
463	PW04M	FLAT WASHER 10MM
464	PLW06M	LOCK WASHER 10MM
465	P0706465	SWITCH BOX
466	P0706466	FLANGE SCREW
467	P0706467	CONTROL PANEL FACE
468	PS07M	PHLP HD SCR M4-.7 X 8
469	P0706469	START BUTTON
470	P0706470	STOP BUTTON
471	P0706471	MAG SWITCH ASSEMBLY MS-12D
471-1	P0706471-1	REAR SWITCH CASE
471-2	P0706471-2	CONTACTOR NHD C-12D 220V
471-3	P0706471-3	OL RELAY NHD NTH-17 14-17A
471-4	P0706471-4	FRONT SWITCH CASE
471-5	P0706471-5	SWITCH CASE SCREW
472	PS06M	PHLP HD SCR M5-.8 X 20
473	PN06M	HEX NUT M5-.8
474	PW02M	FLAT WASHER 5MM
475	P0706475	SWITCH PLATE
476	PCAP04M	CAP SCREW M6-1 X 10
477	PW03M	FLAT WASHER 6MM
478	PK20M	KEY 5 X 5 X 15

Labels & Cosmetic



REF	PART #	DESCRIPTION
501	P0609402	CUTTERHEAD FENCE LABEL
502	P0706502	CUTTING DEPTH SCALE
503	PLABEL-14	ELECTRICITY LABEL
504	P0706467	CONTROL PANEL FACE
505	PLABEL-12A	READ MANUAL LABEL
506	PLABEL-63	DISCONNECT 220V LABEL
507	P0706507	PRE-WIRED 220V 1-PH LABEL
508	P0706402	HANDWHEEL DIRECTION LABEL
509	PLABEL-55	ENTANGLEMENT LABEL

REF	PART #	DESCRIPTION
510	G8589	GRIZZLY NAME PLATE-LARGE
511	P0706511	MODEL NUMBER LABEL
512	P0706512	MACHINE ID LABEL
513	PLABEL-57	GLASSES/RESPIRATOR LABEL
514	PLABEL-51	CUTTERHEAD WARNING LABEL
515	PPAINT-1	GRIZZLY GREEN TOUCH UP PAINT
516	PPAINT-11	PUTTY TOUCH UP PAINT
517	PPAINT-16	RED TOUCH UP PAINT

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinetmaker & FDM
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____Yes _____No

8. Would you recommend Grizzly Industrial to a friend? _____Yes _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____Yes _____No

10. Comments: _____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.